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Fig 1

A

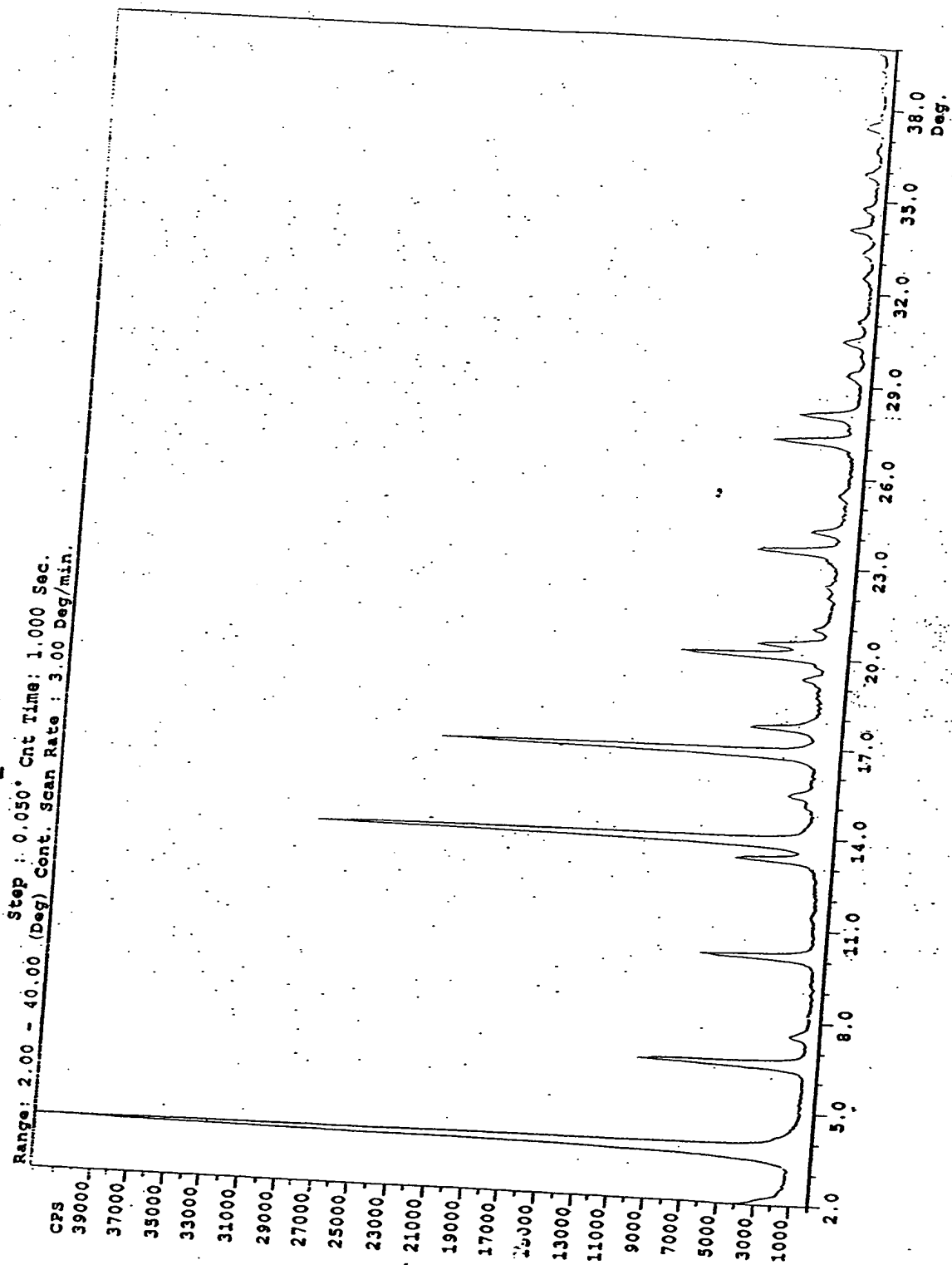


Fig. 2 C

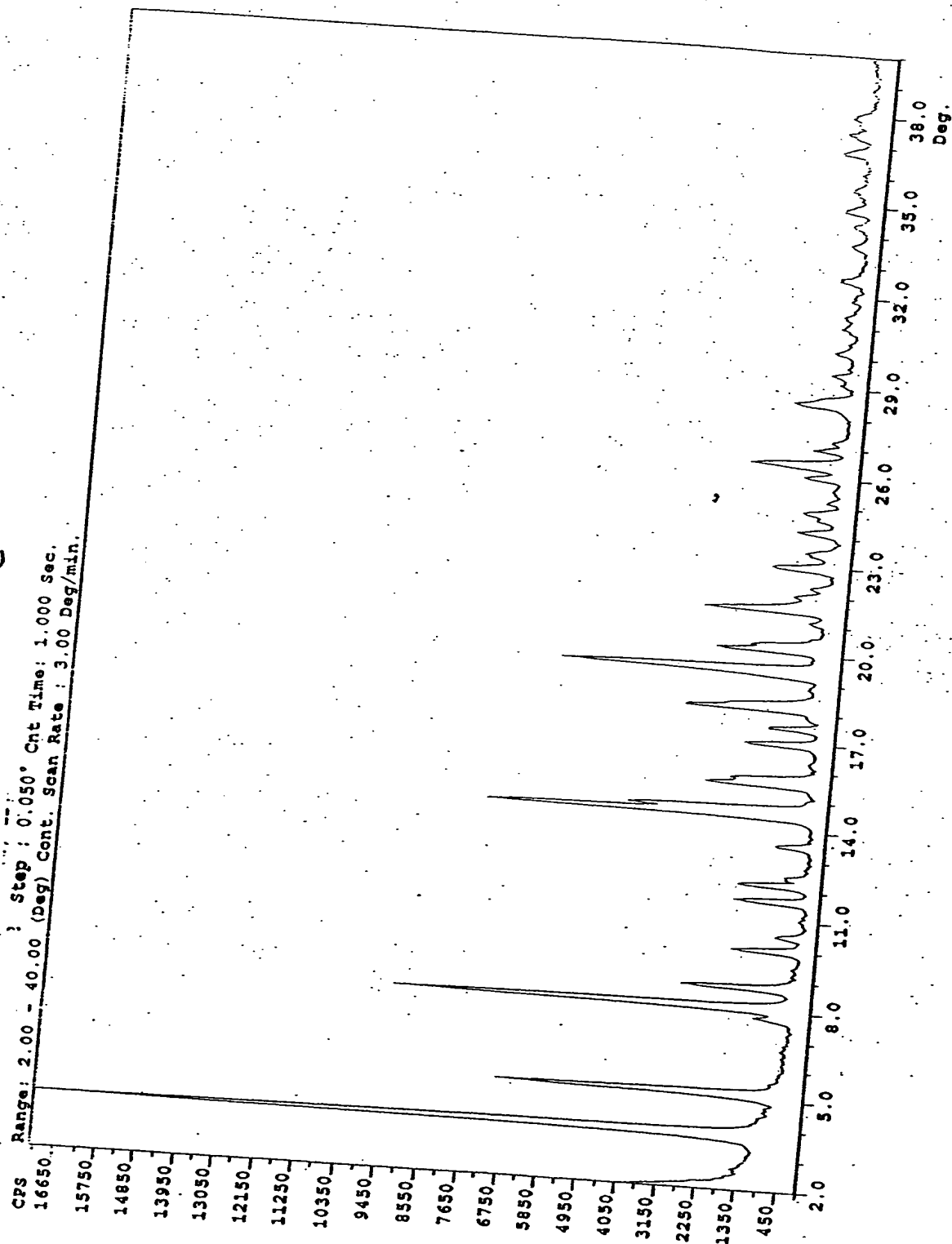


Fig 3 D

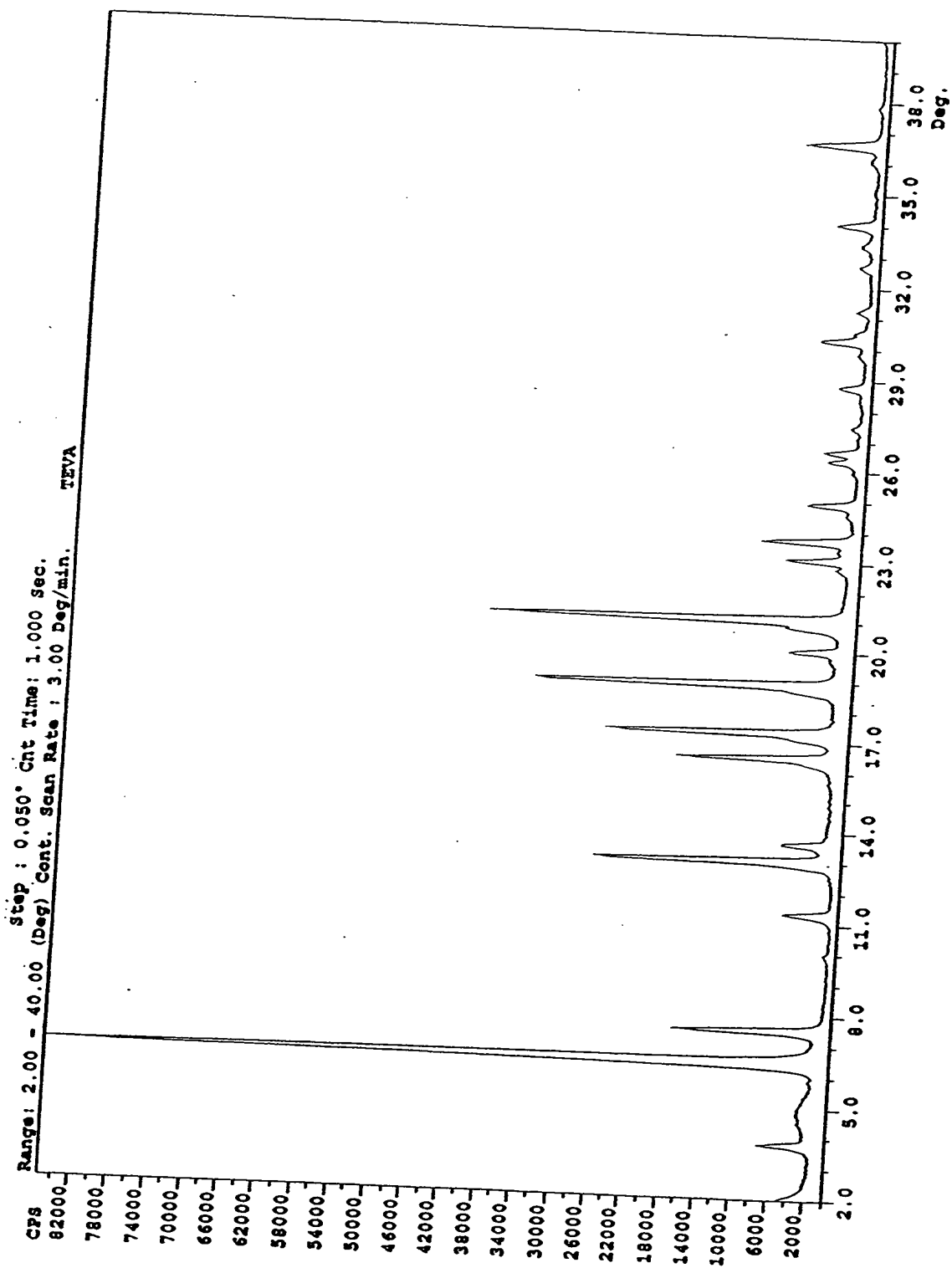


Fig 4 E

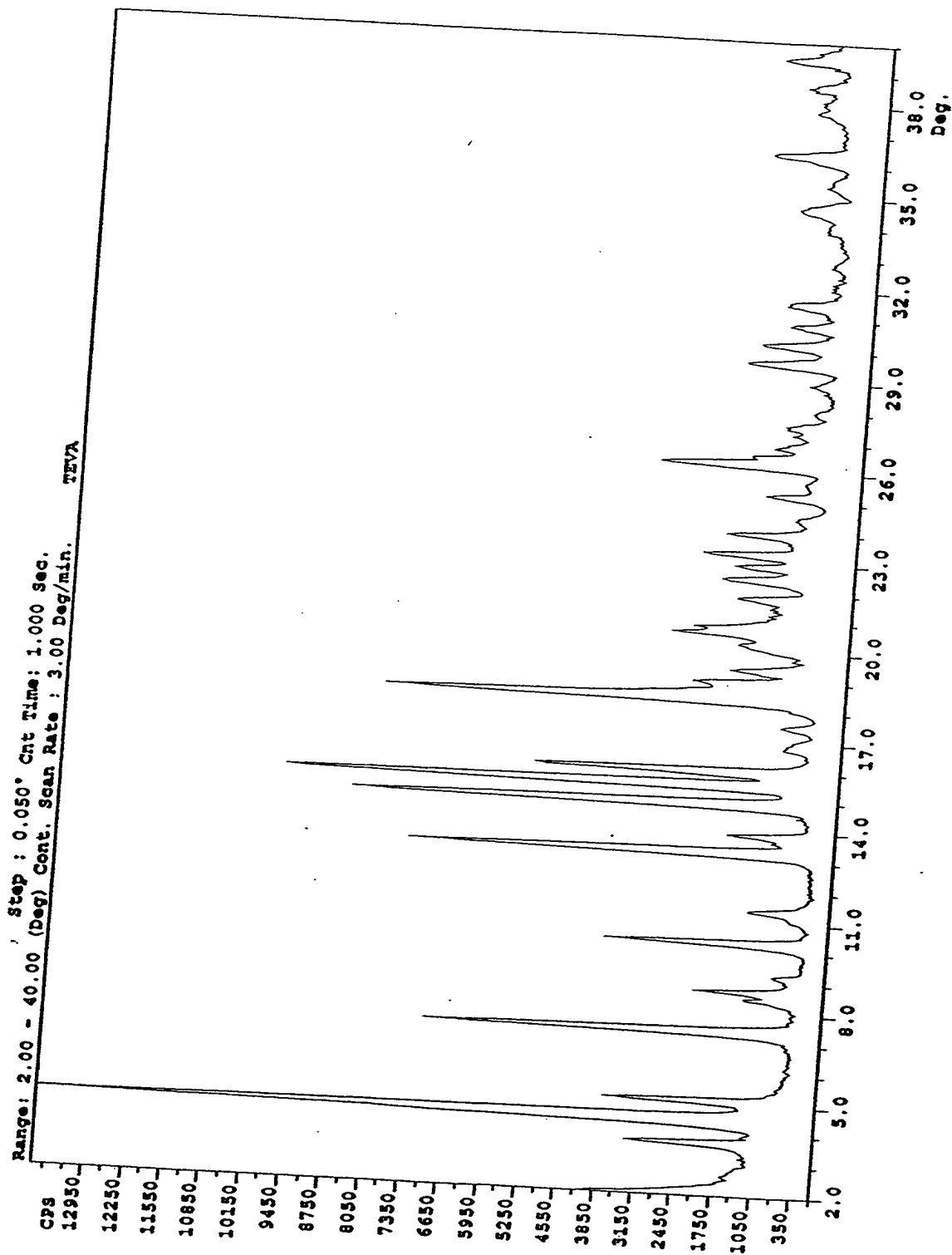


Fig. 5

F

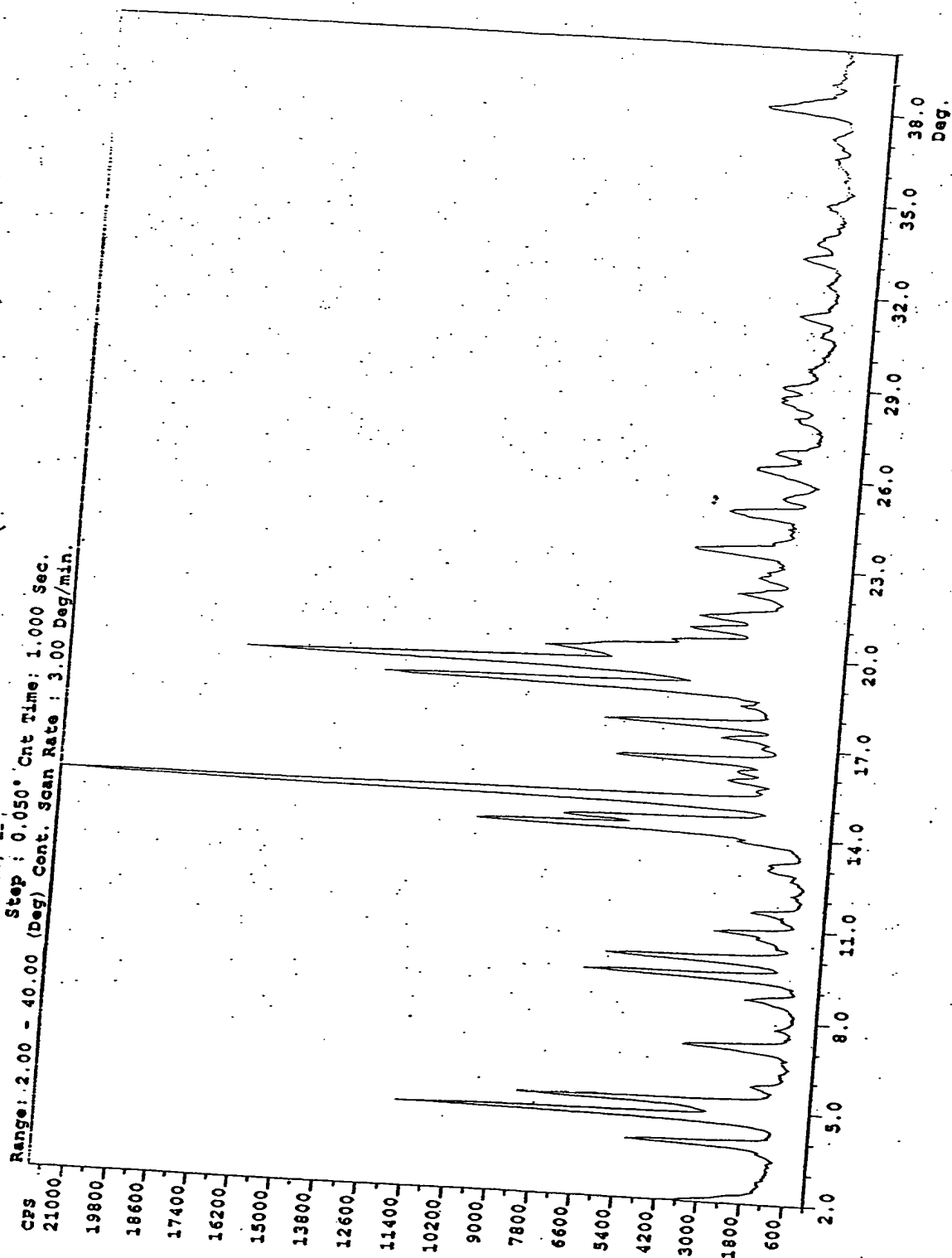


Fig. 6

G

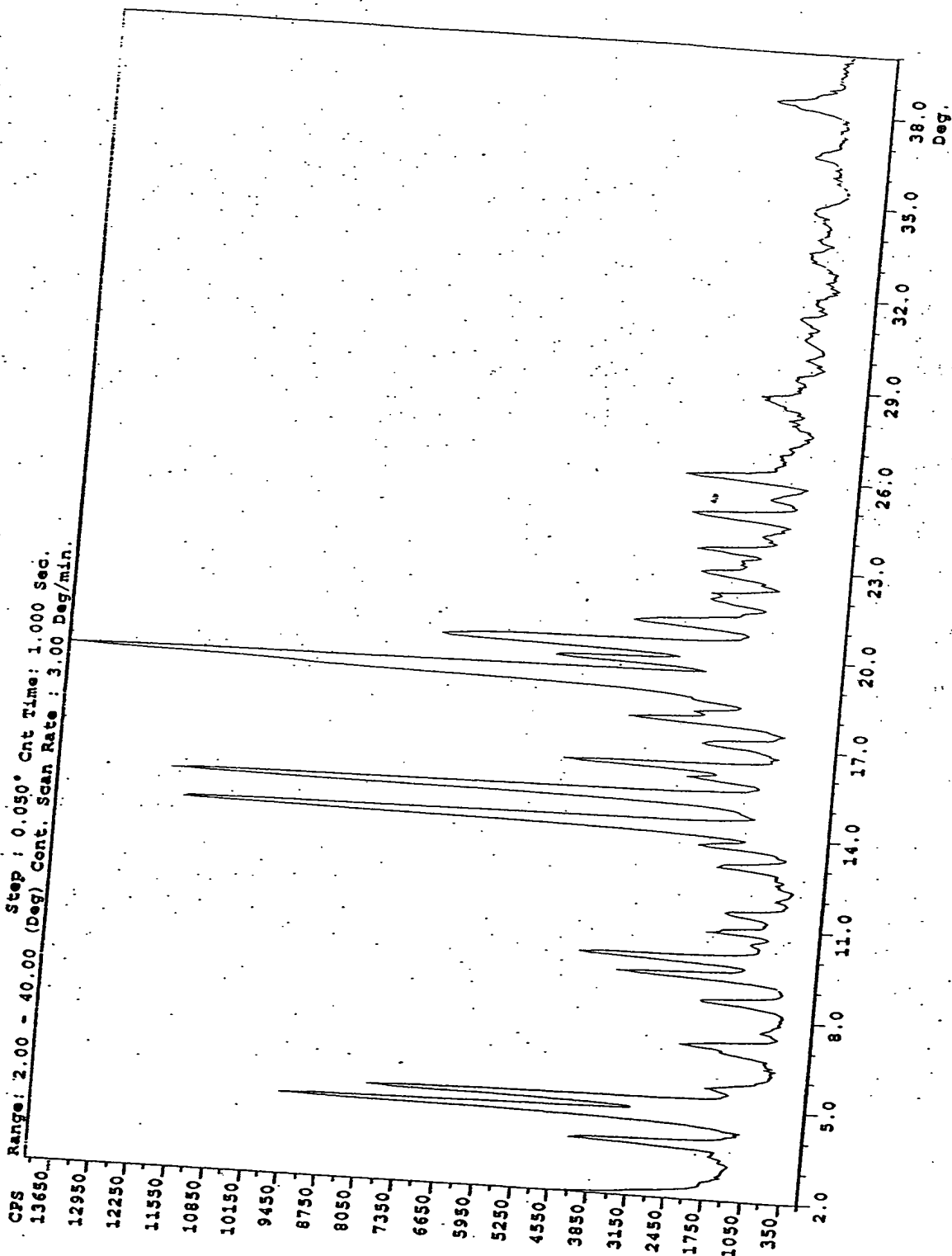


Fig 7 I

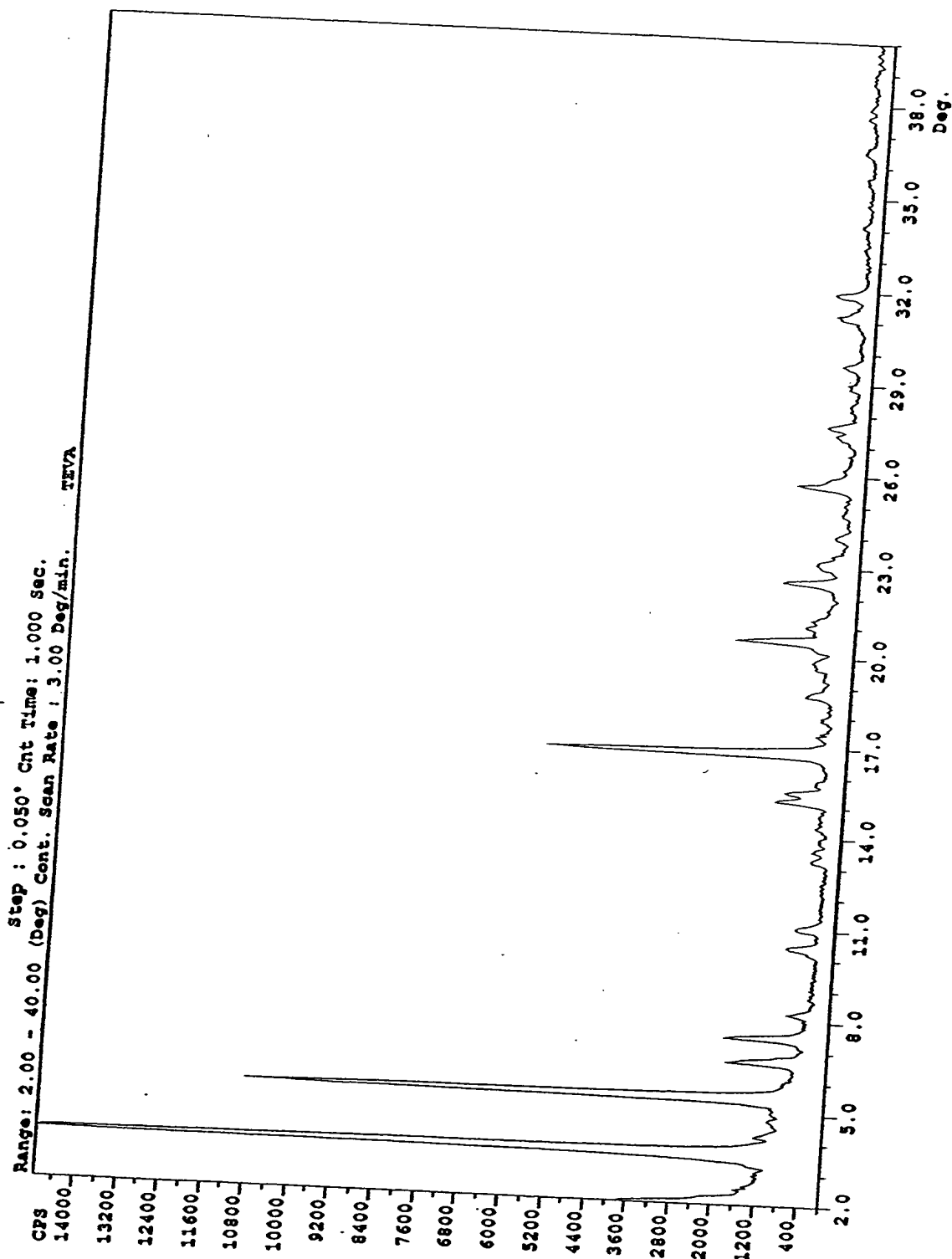




Fig. 8 3

Range: 2.00 - 40.00 (Deg) Step: 0.050° Cnt Time: 1.000 Sec.  
Cont. Scan Rate: 3.00 Deg/min.

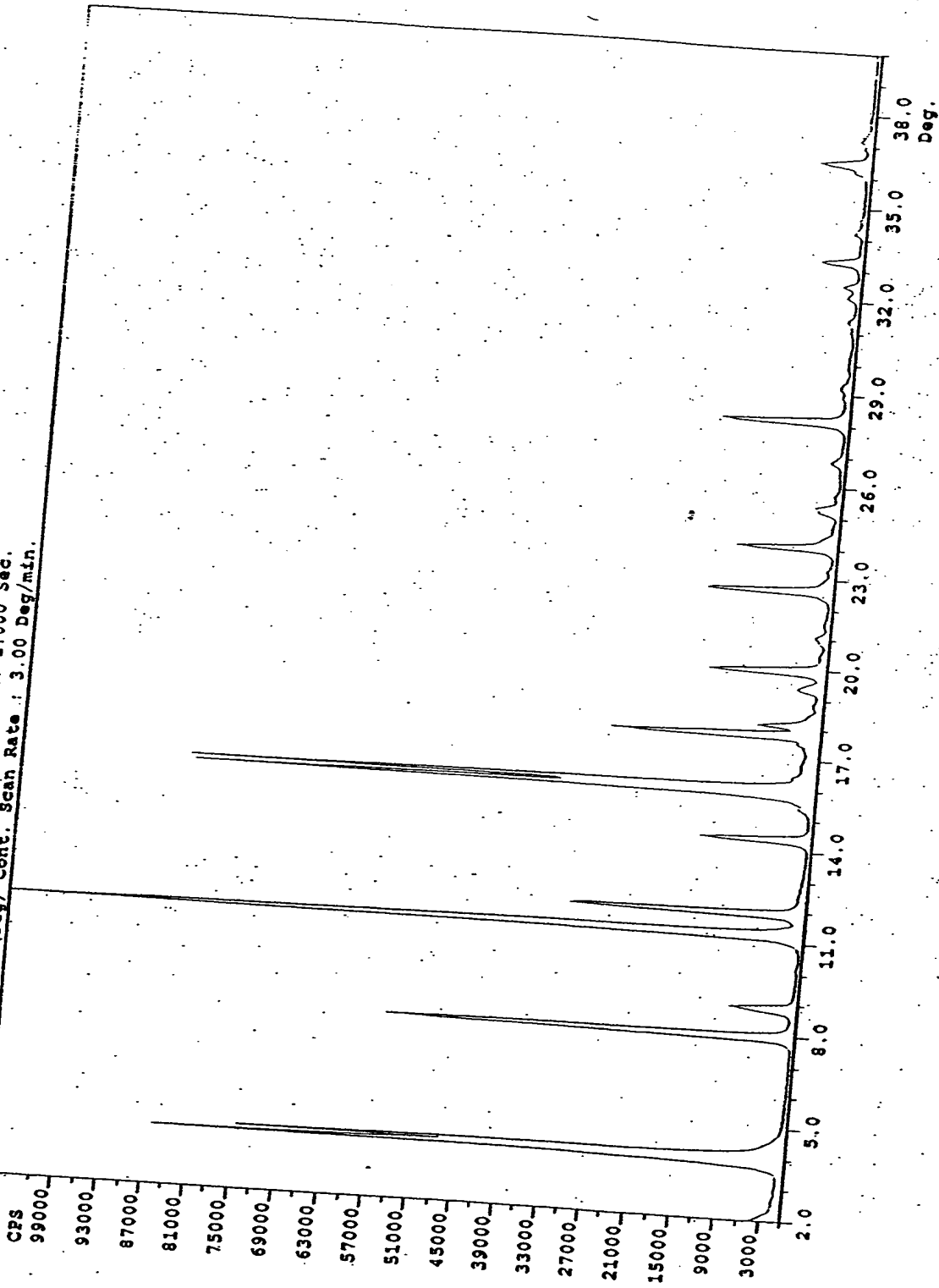


Fig. 9

K

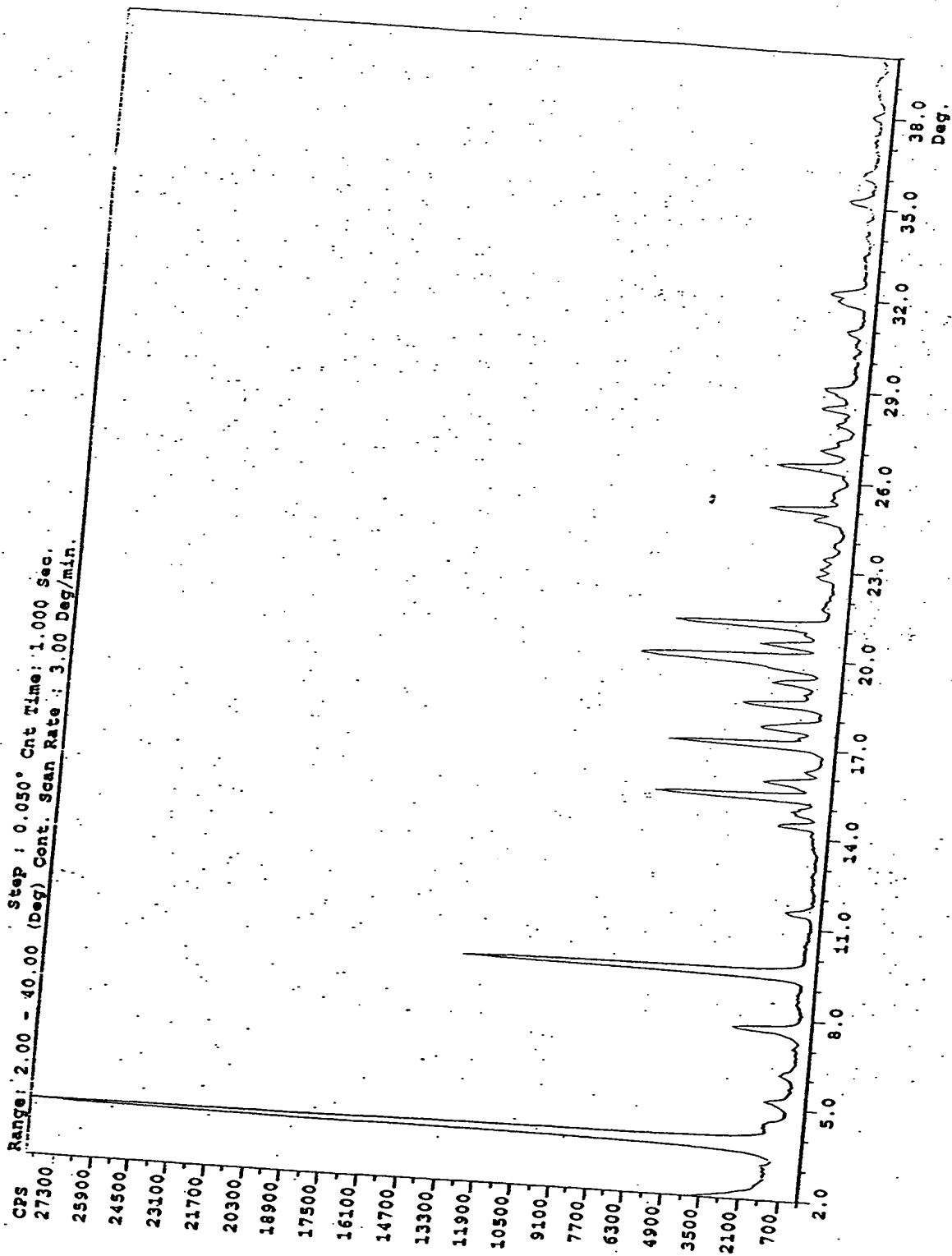
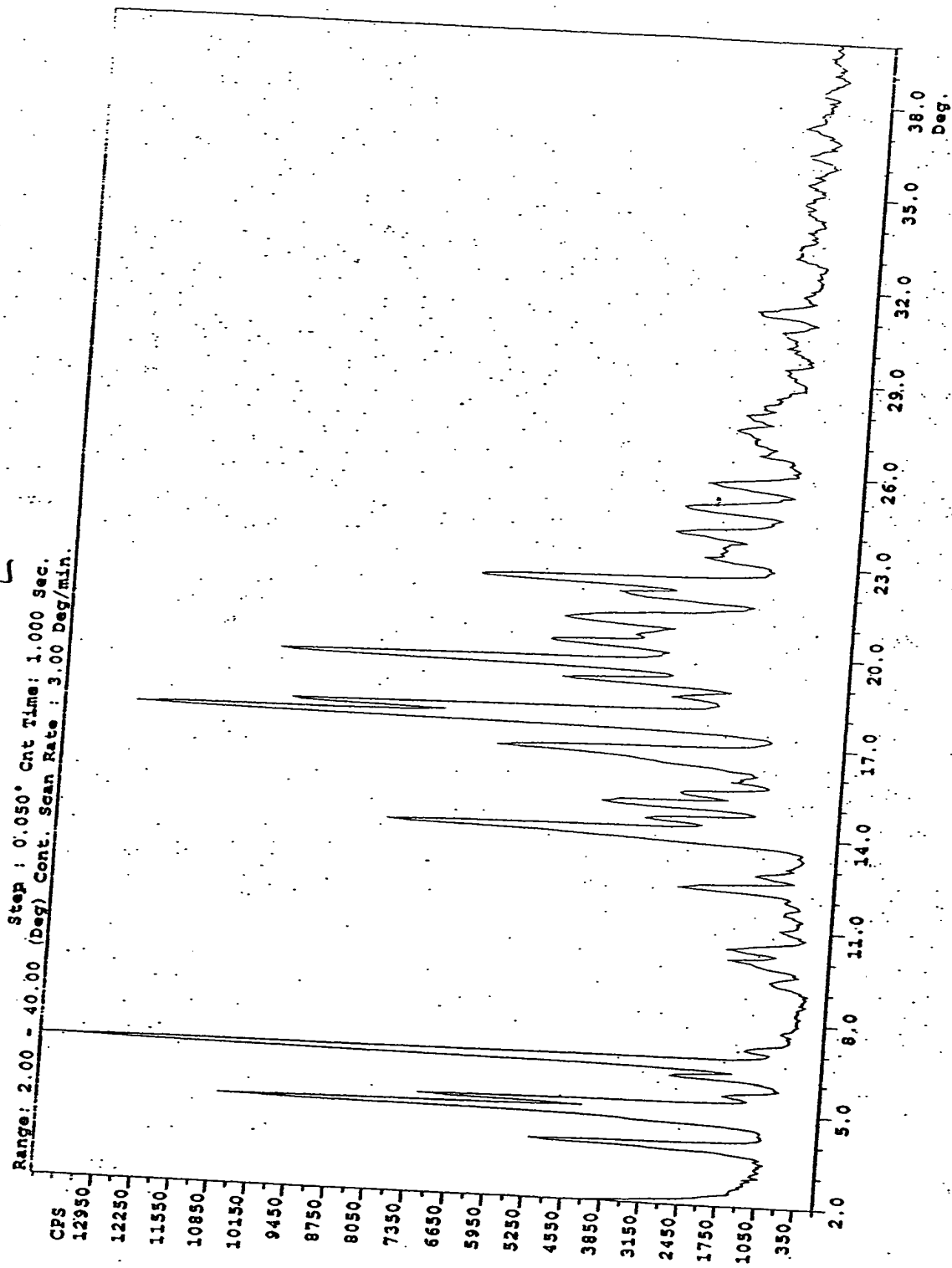


Fig. 10 L



⊕

Fig. 11

M

Range: 2.00 - 40.00 (Deg) Step: 0.050° Cnt Time: 1.000 Sec.  
Cont. Scan Rate: 3.00 Deg/min.

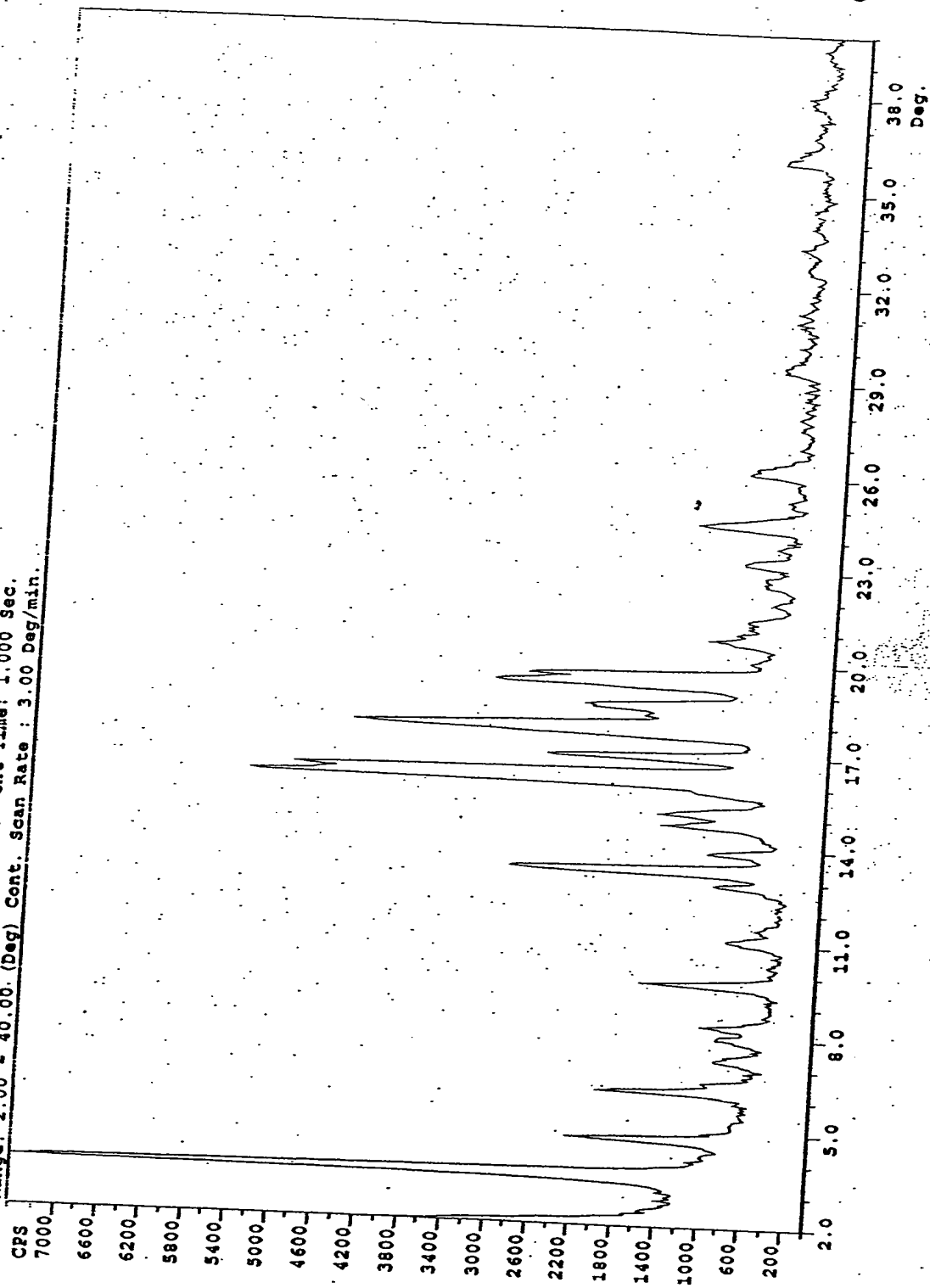


Fig. 12 N

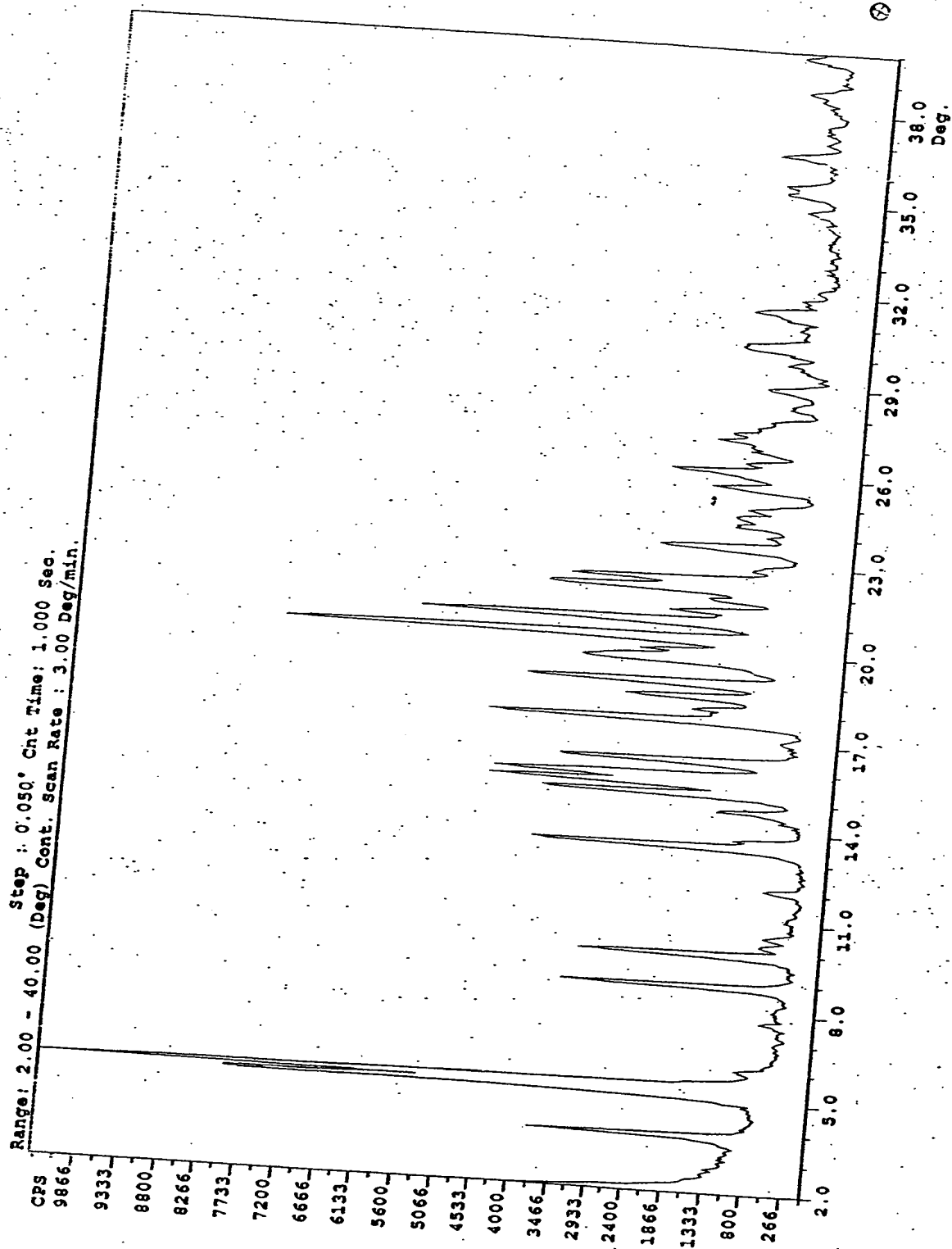


Fig. 13 0

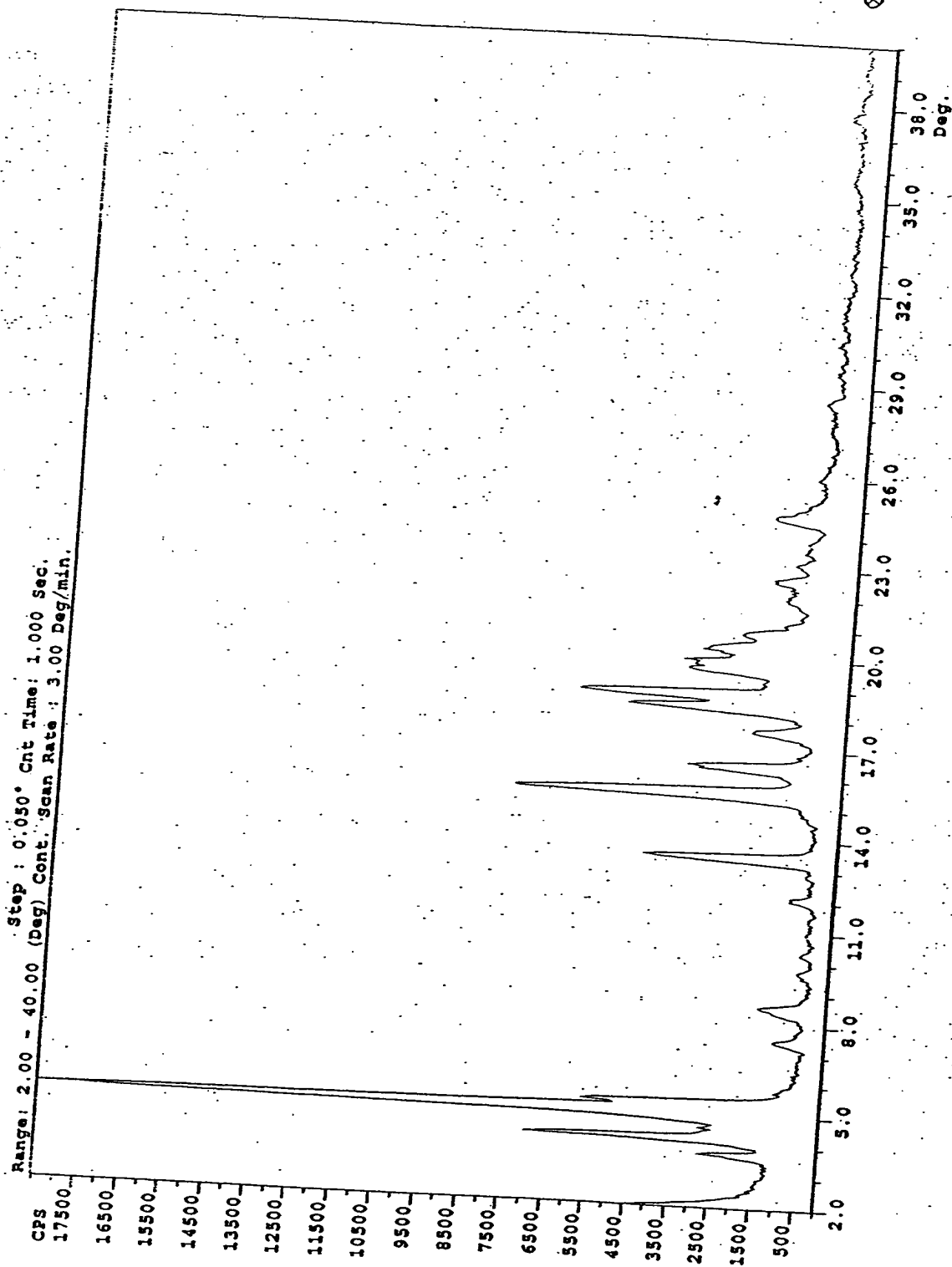


Fig. 14 p

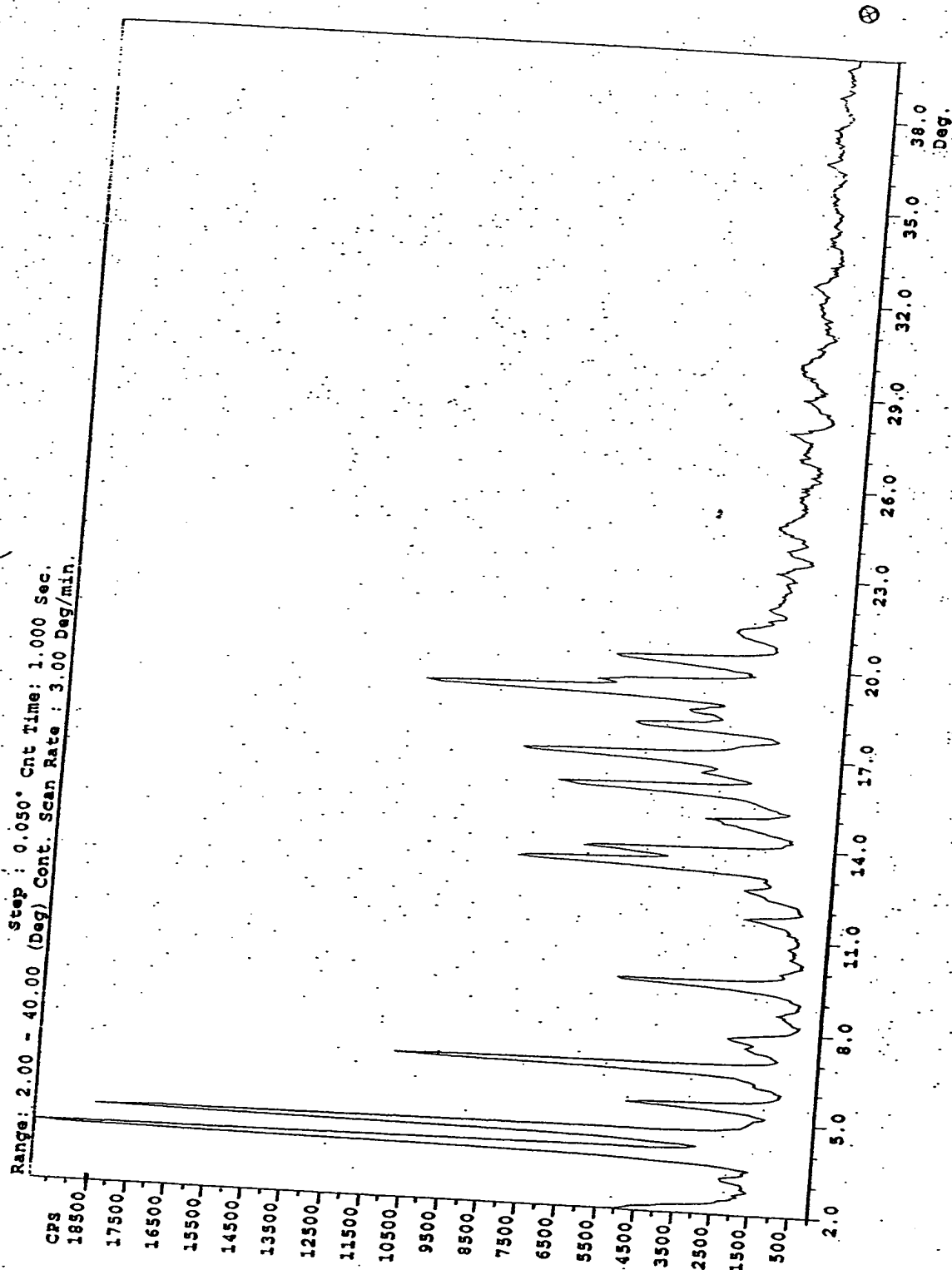


Fig. 15 Q

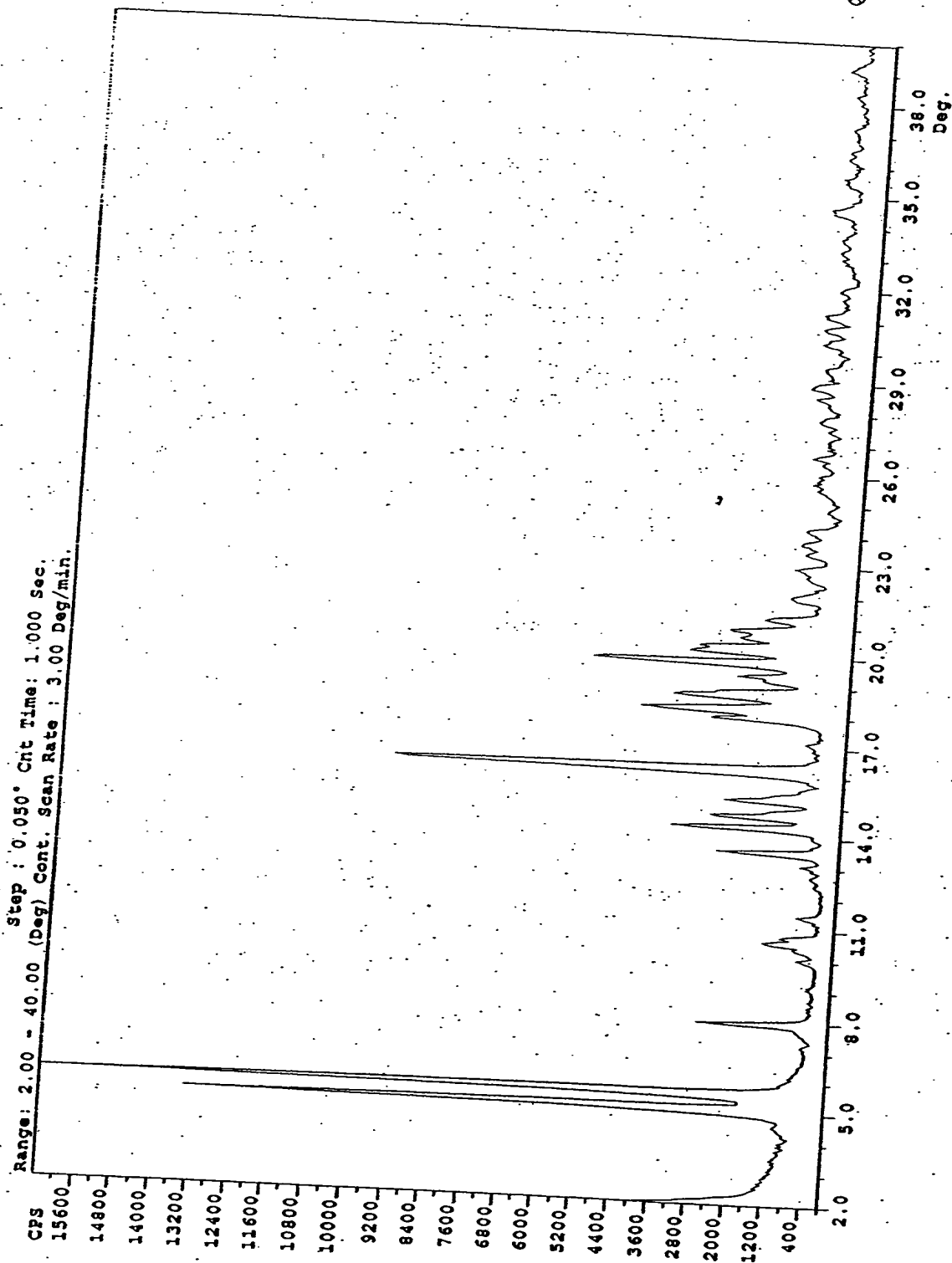




Fig. 16

T

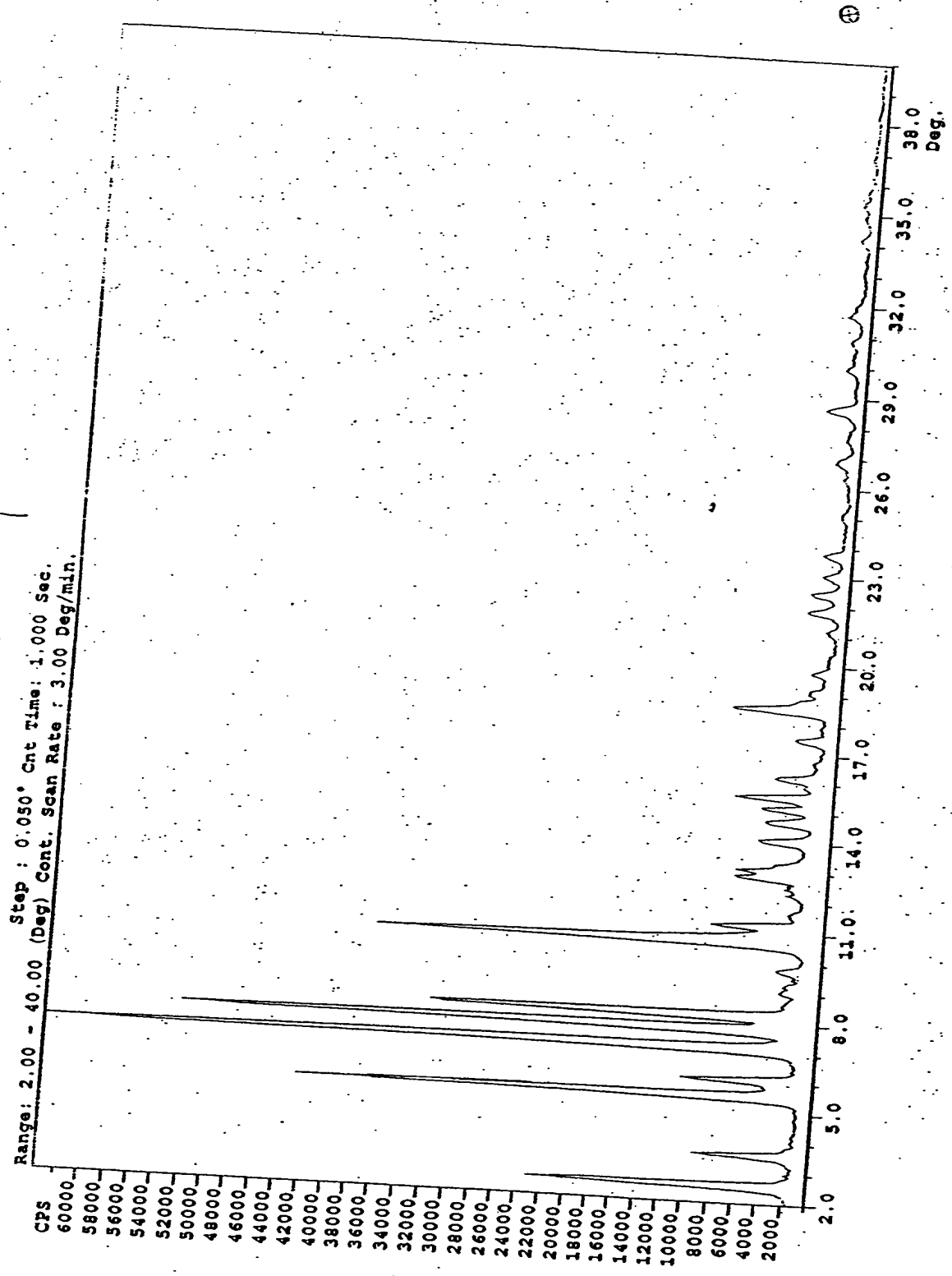


Fig. 17 u

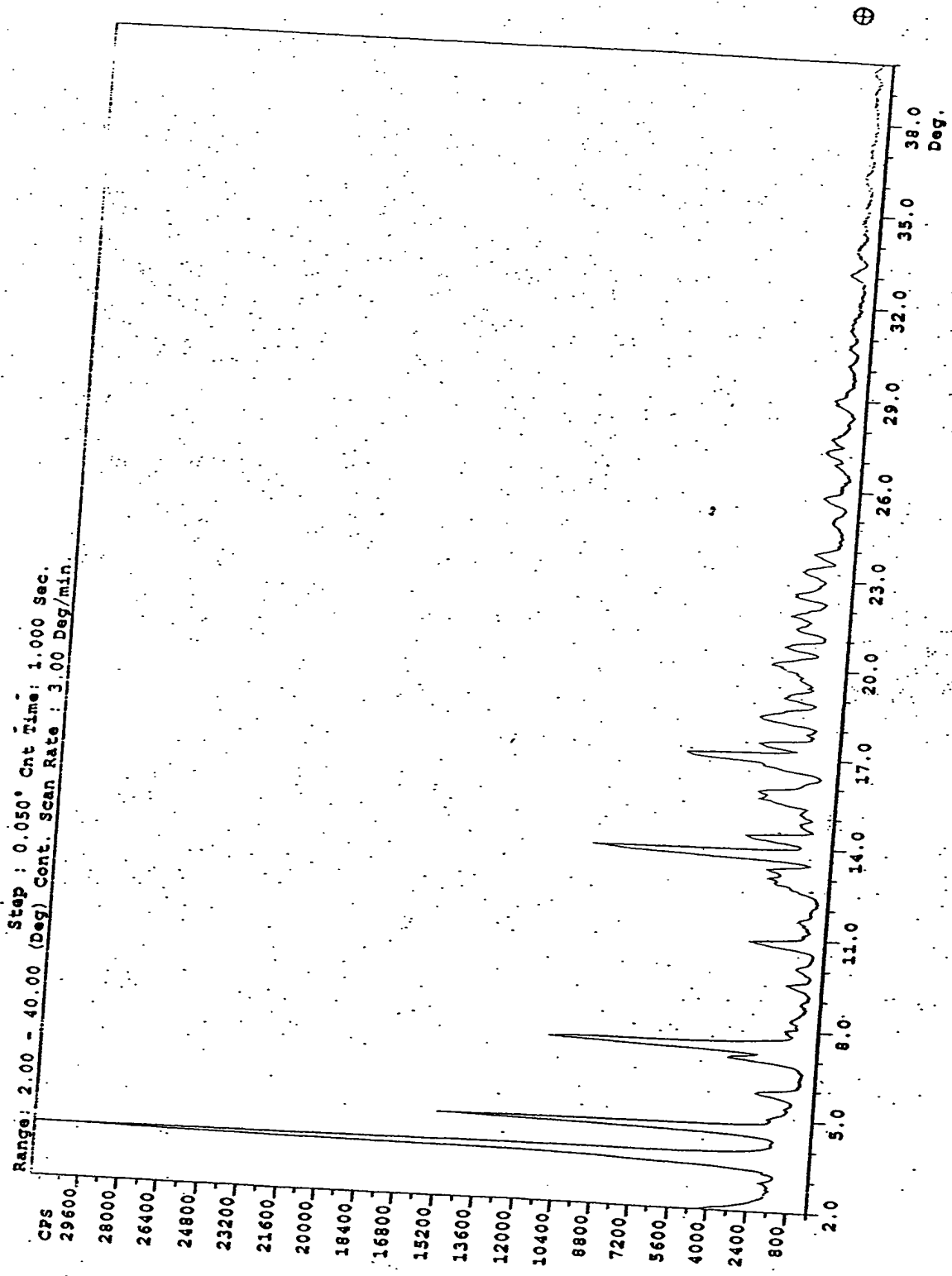


Fig. 18

✓

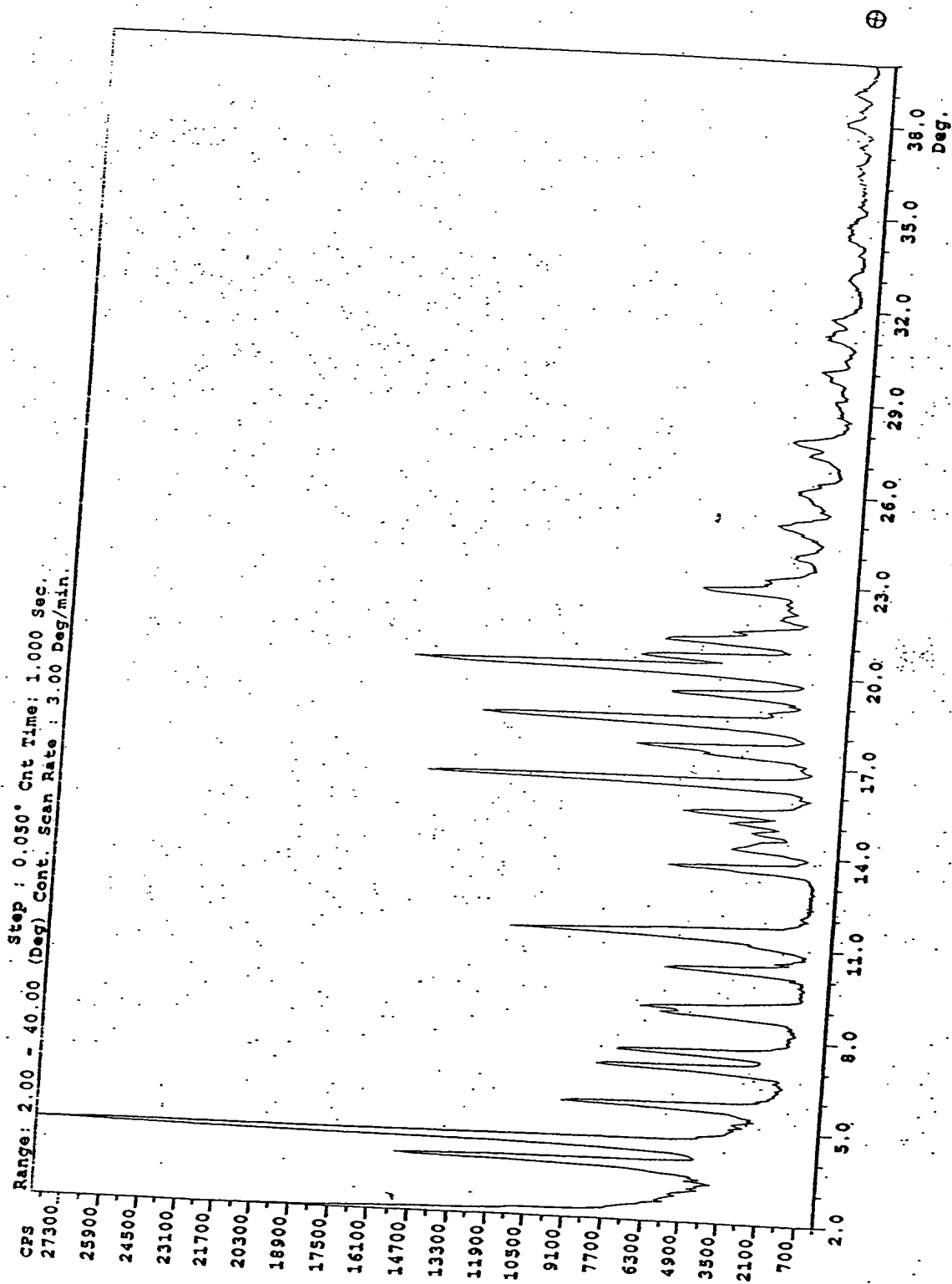


Fig 19  $\gamma$

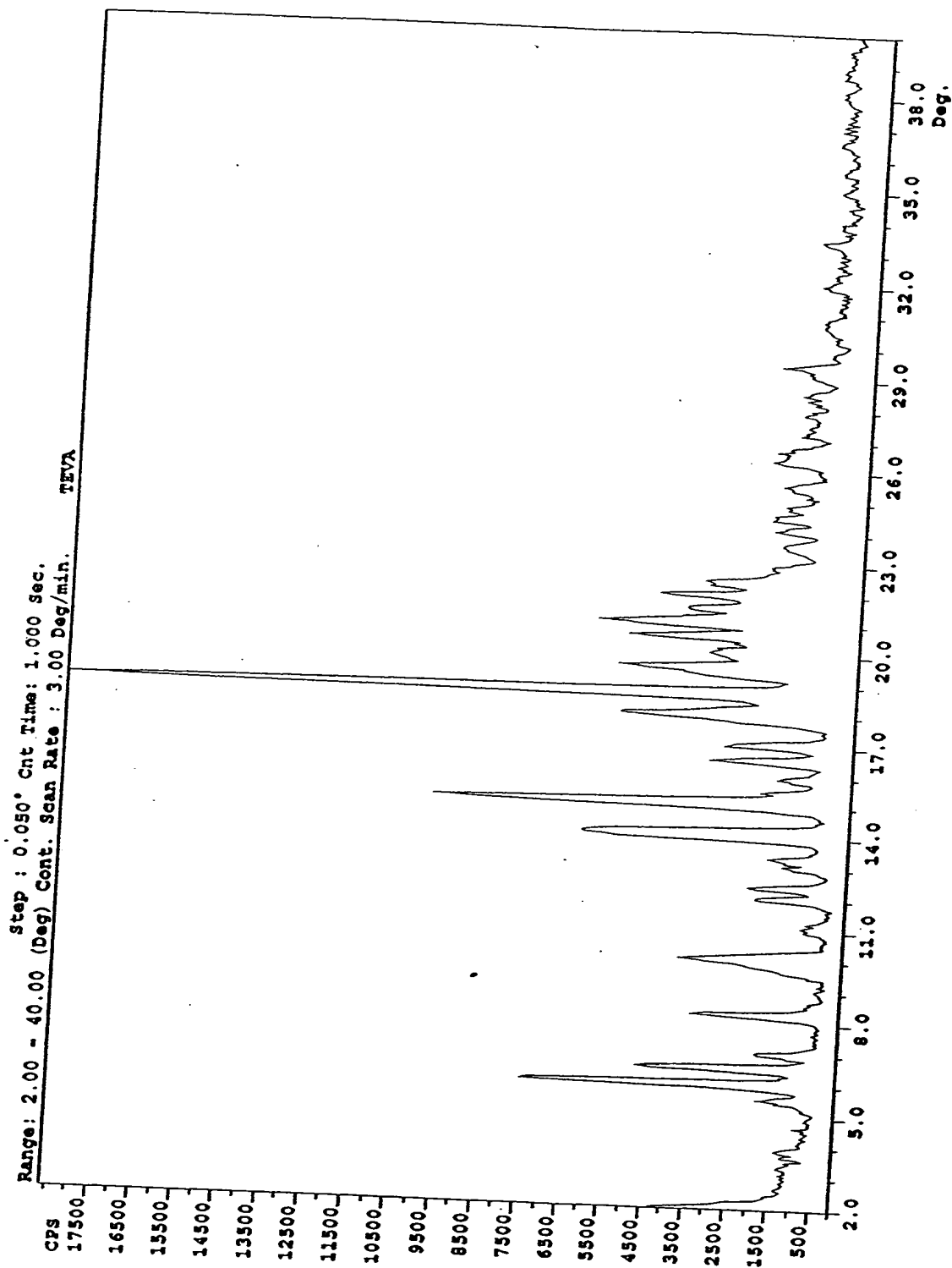


Figure 20 - Nateglinide Form Z

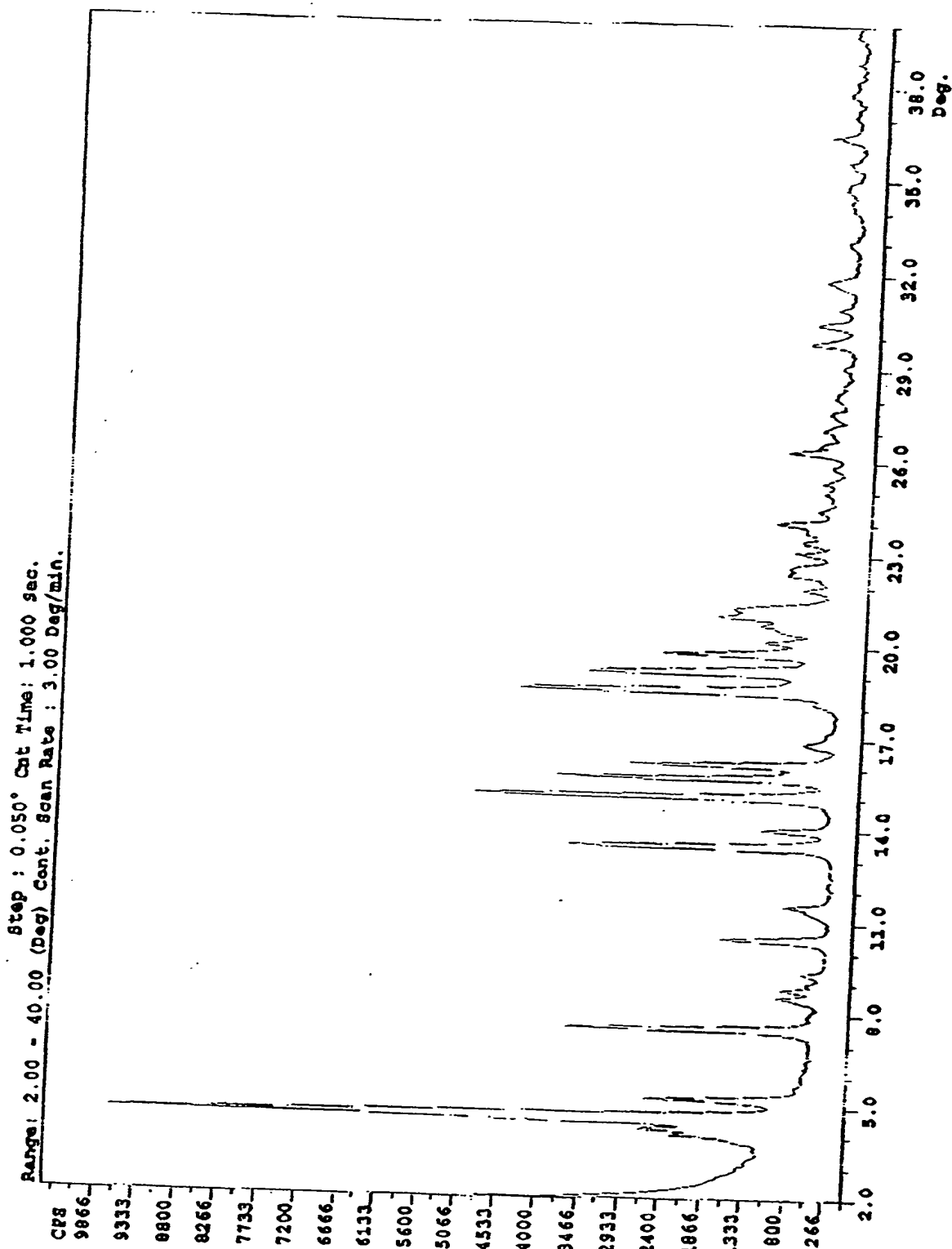


fig 2p x

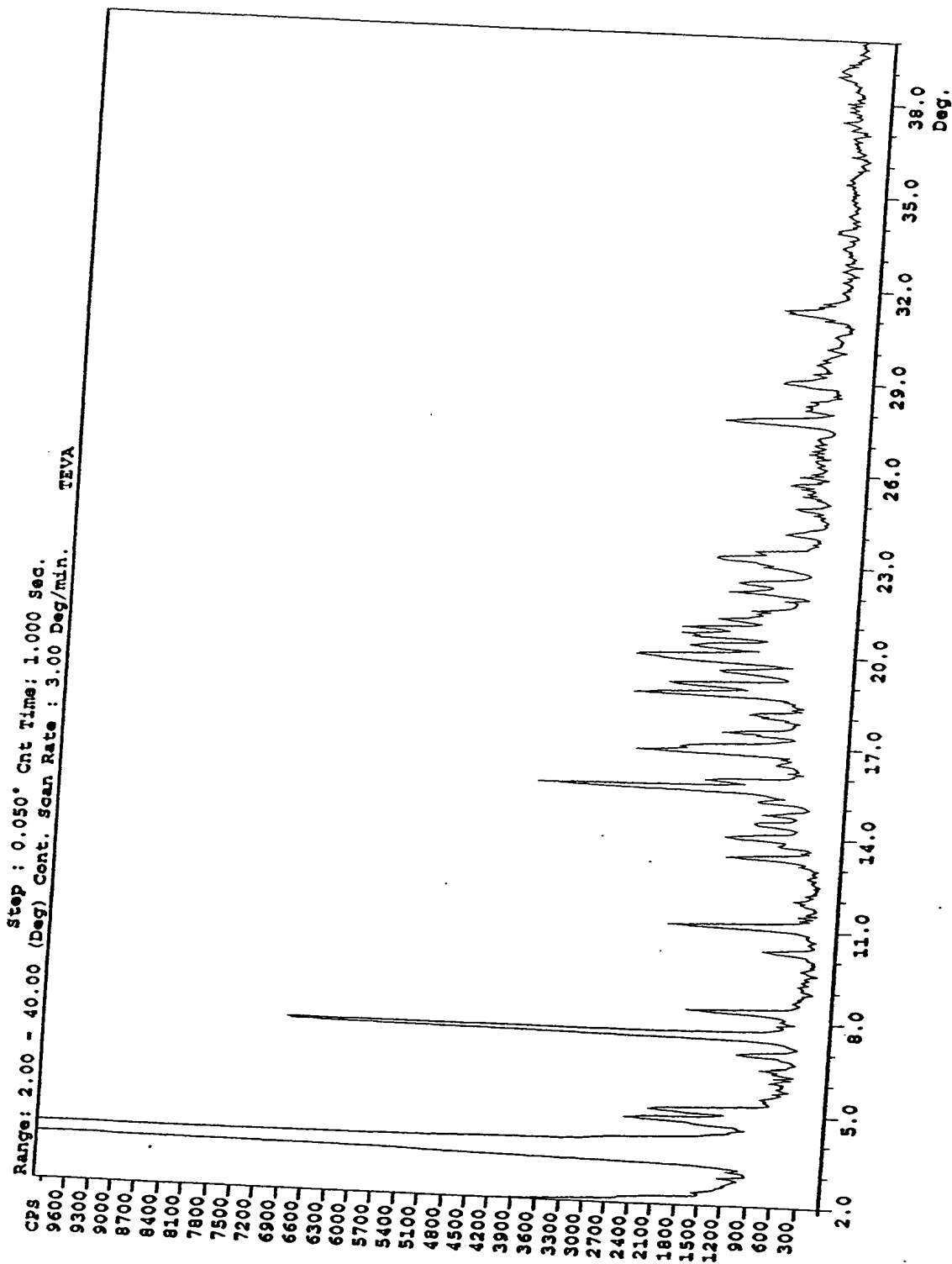


Fig. 22 B

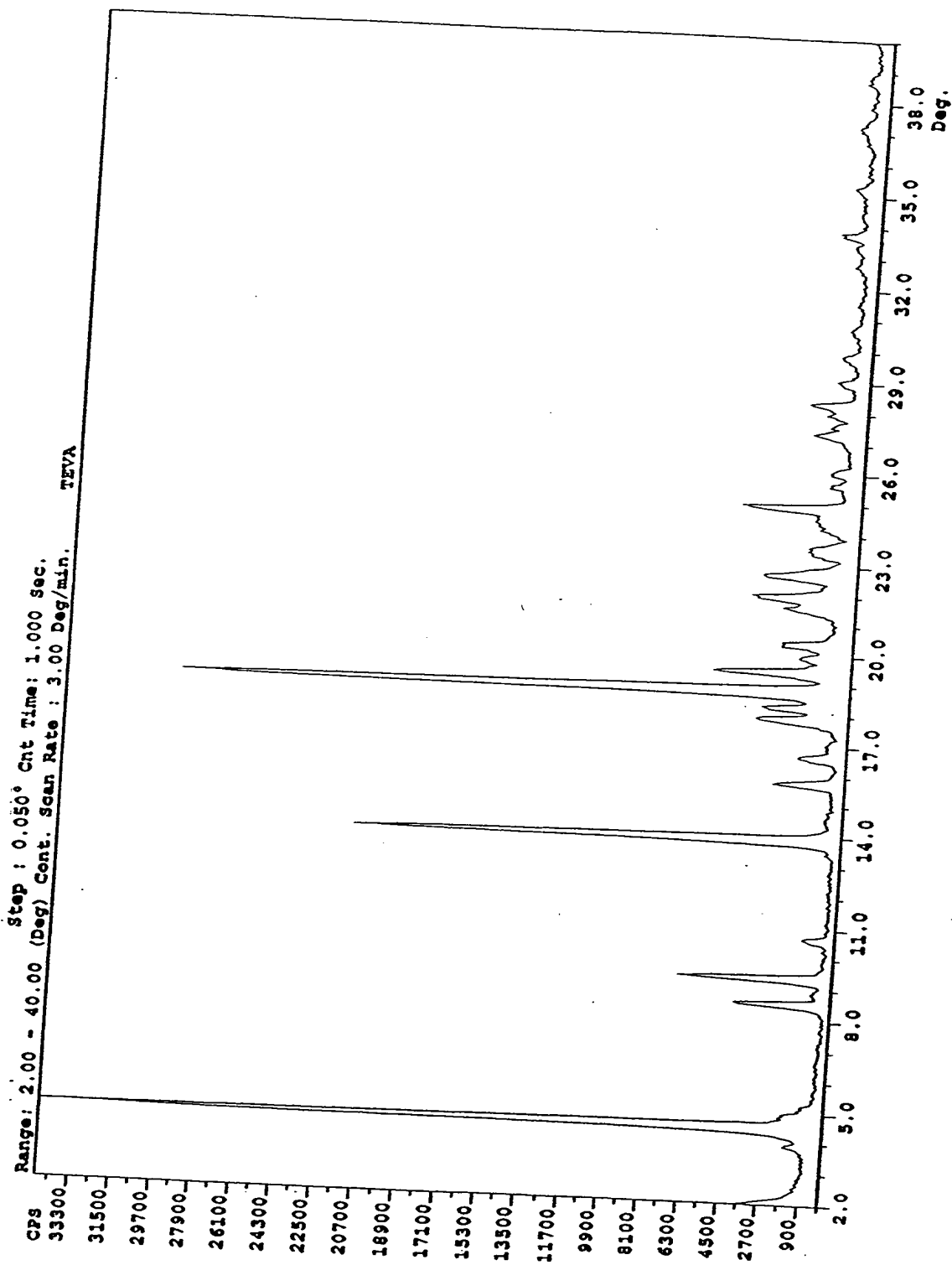


fig 23 10

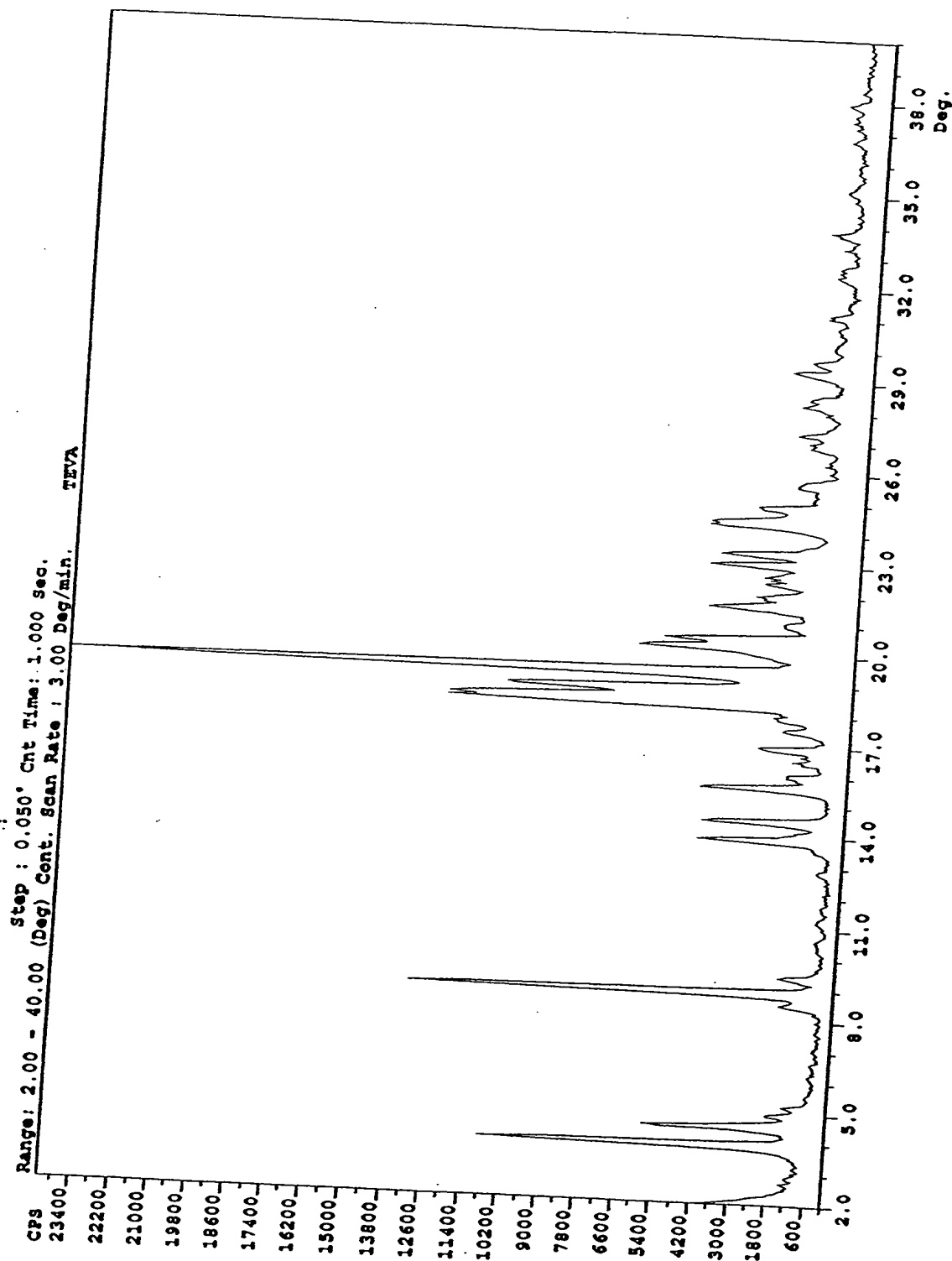




Fig 24

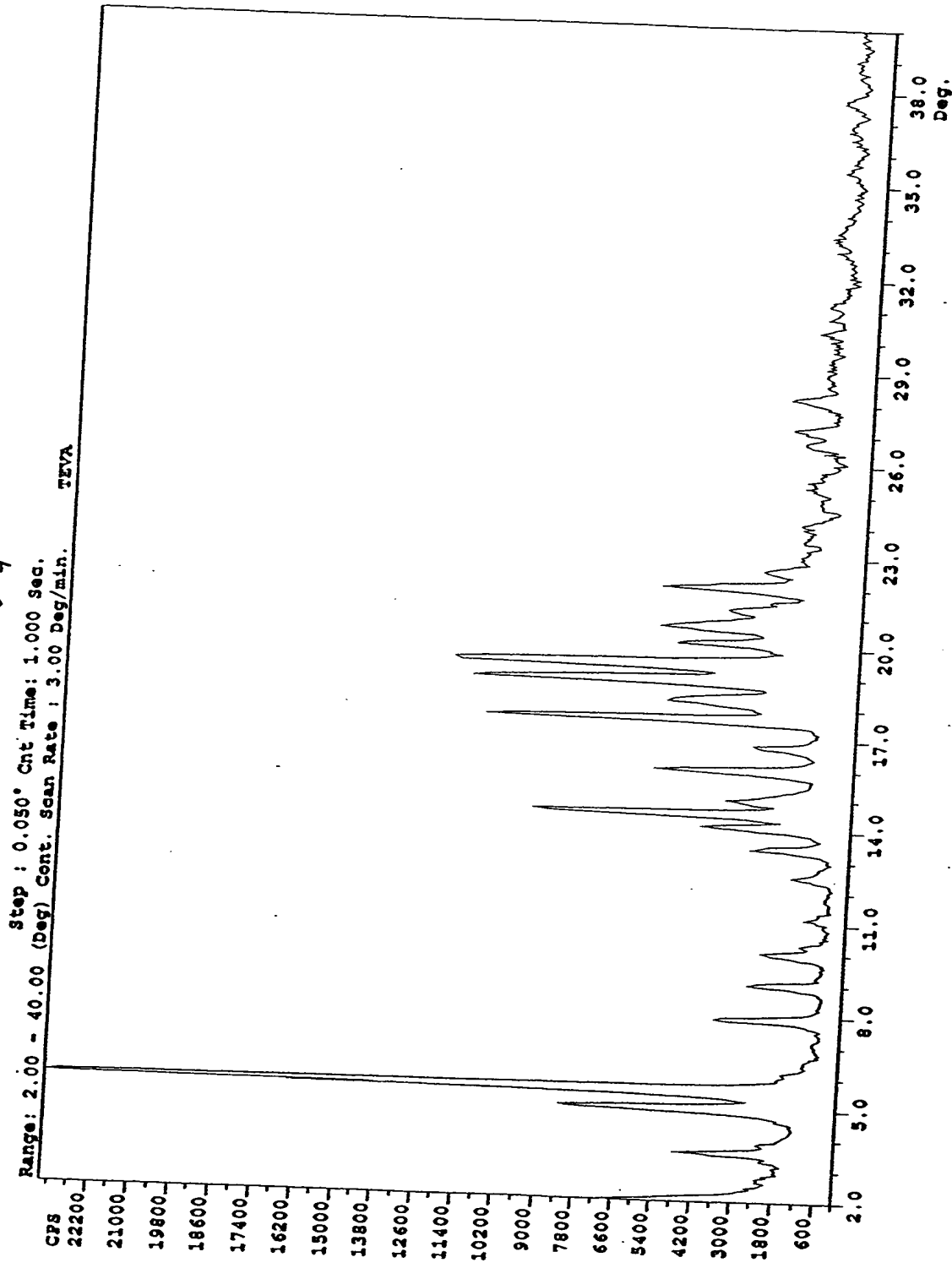


Fig 25 E

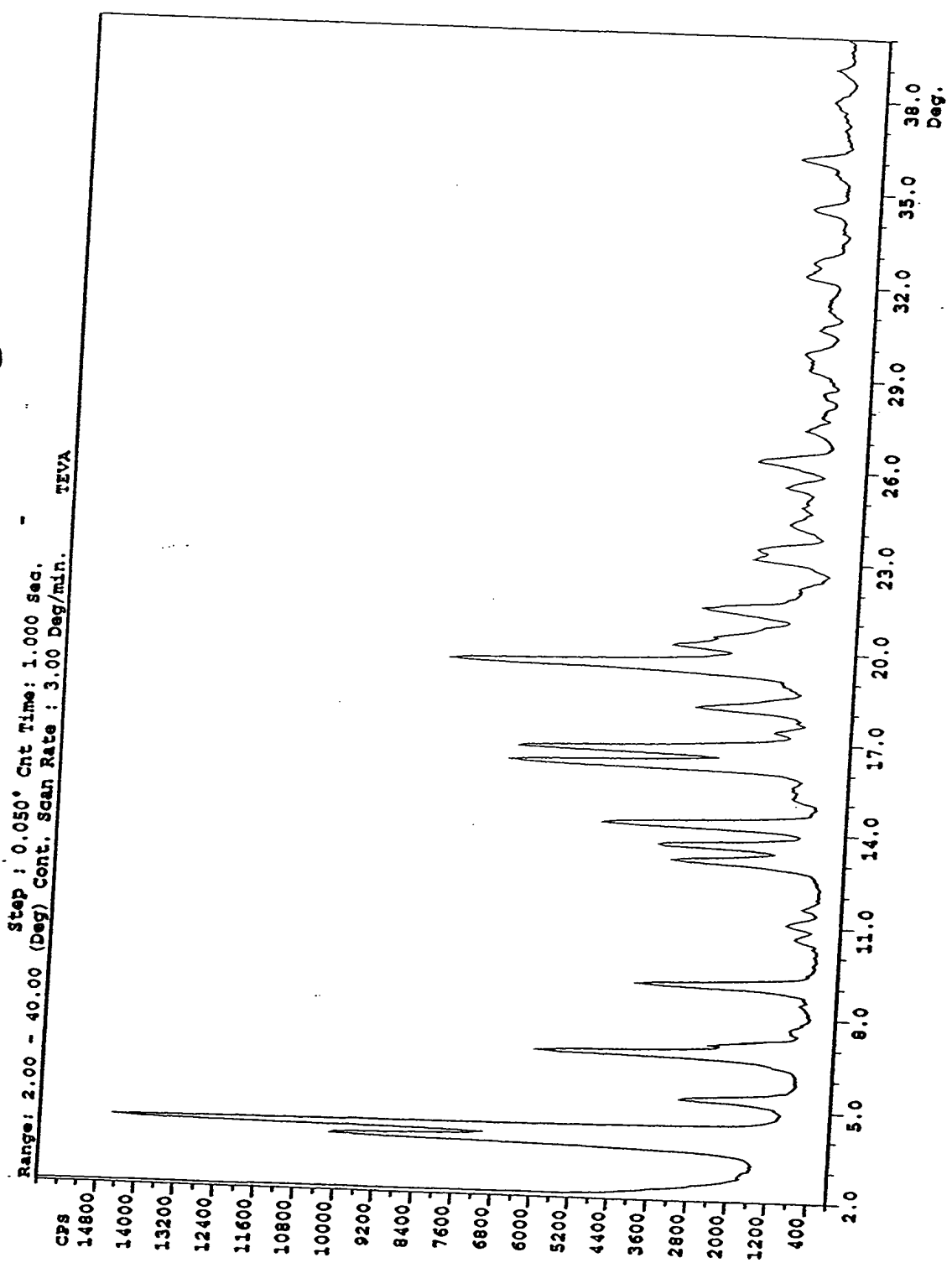
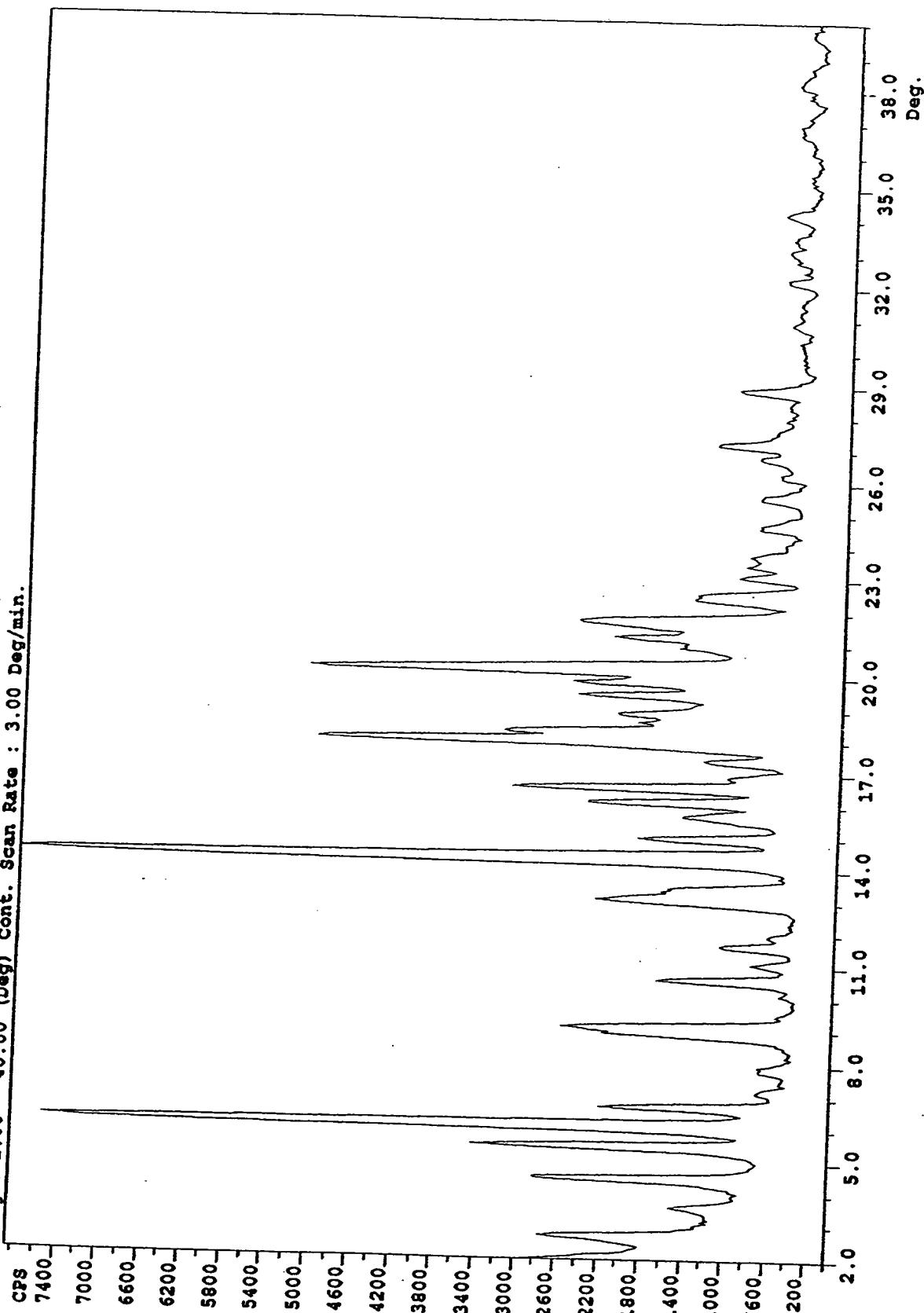


FIGURE 26

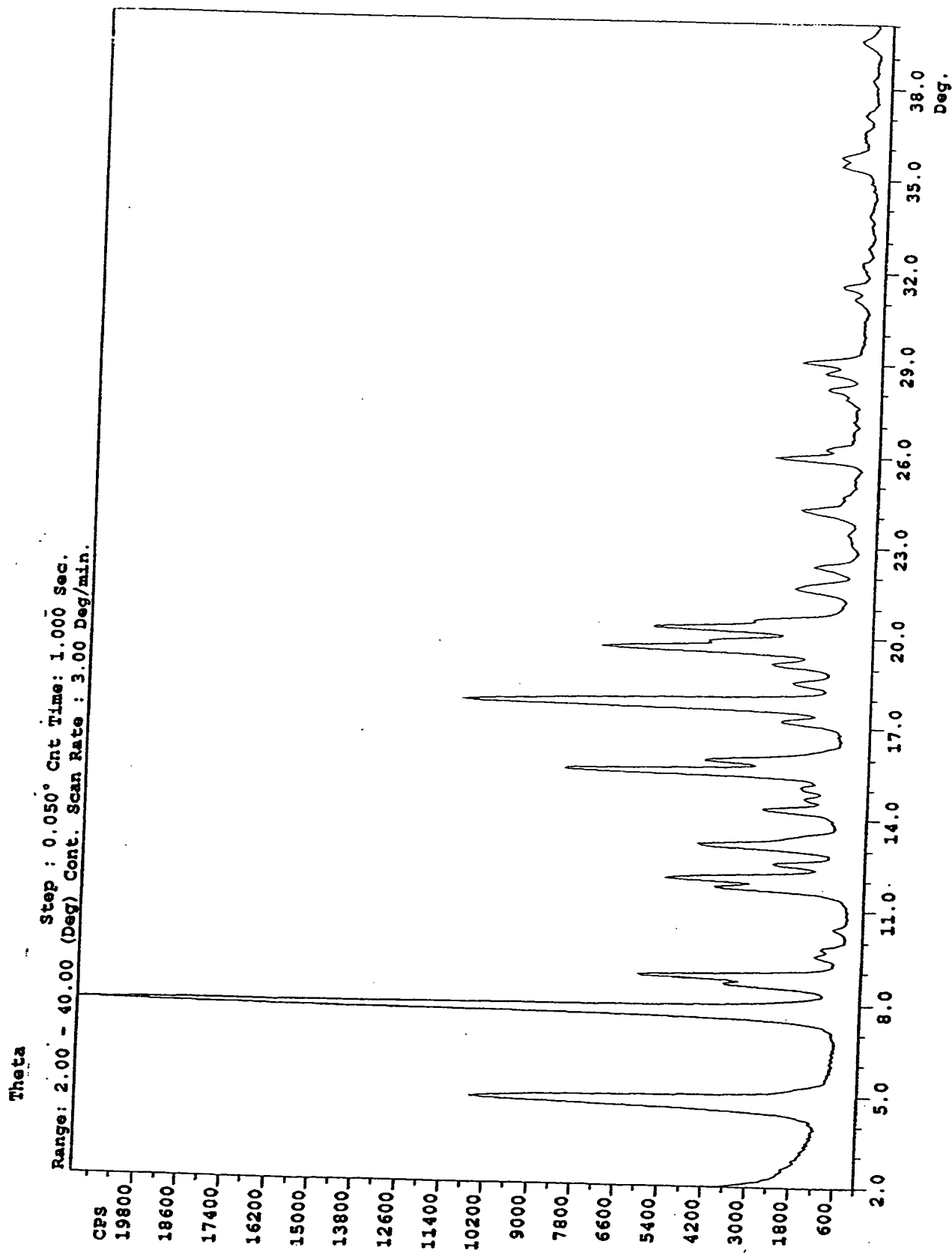
Sigma

Range: 2.00 - 40.00 (Deg) Cnt Time: 1.000 Sec.  
Step: 0.050° Cnt Rate: 3.00 Deg/min.



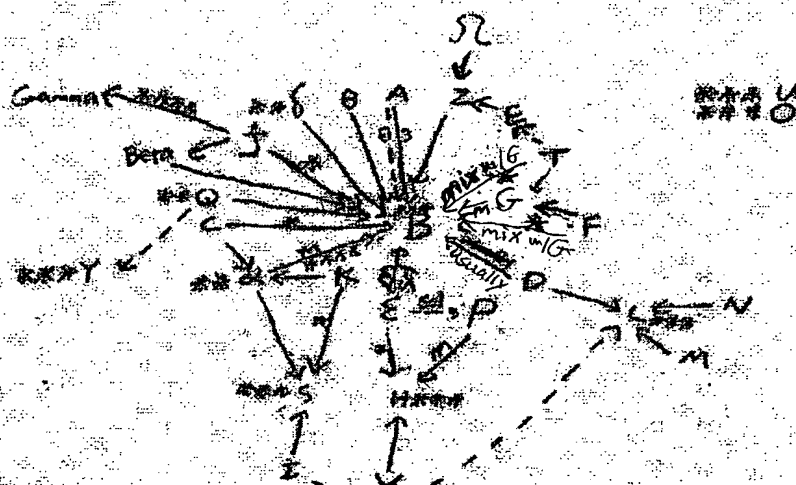
Form  $\alpha$  (5)

FIGURE 23



Form 8

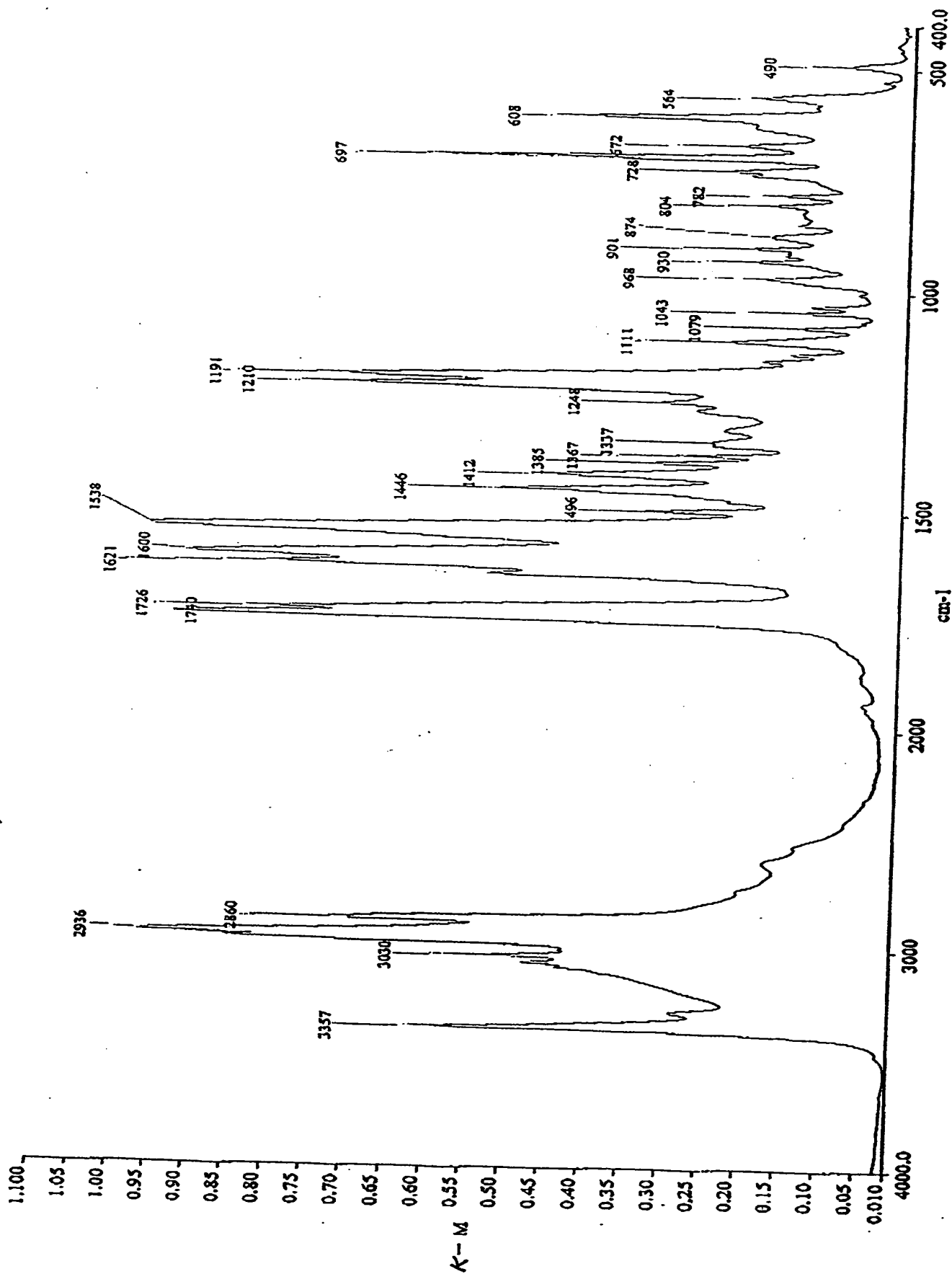
Figure 28 - Thermal stability chart



\* Transformation may proceed through another form  
 \*\* Thermally stable at lower heating temperatures (~50°C)  
 \*\*\* Thermally stable forms  
 --- Transformation after storage at room temperature in mixture with starting form  
 \*\*\*\* When starting material contains seeds.  
 Sol Results might vary depending on the solvate of Form Epsilon used.

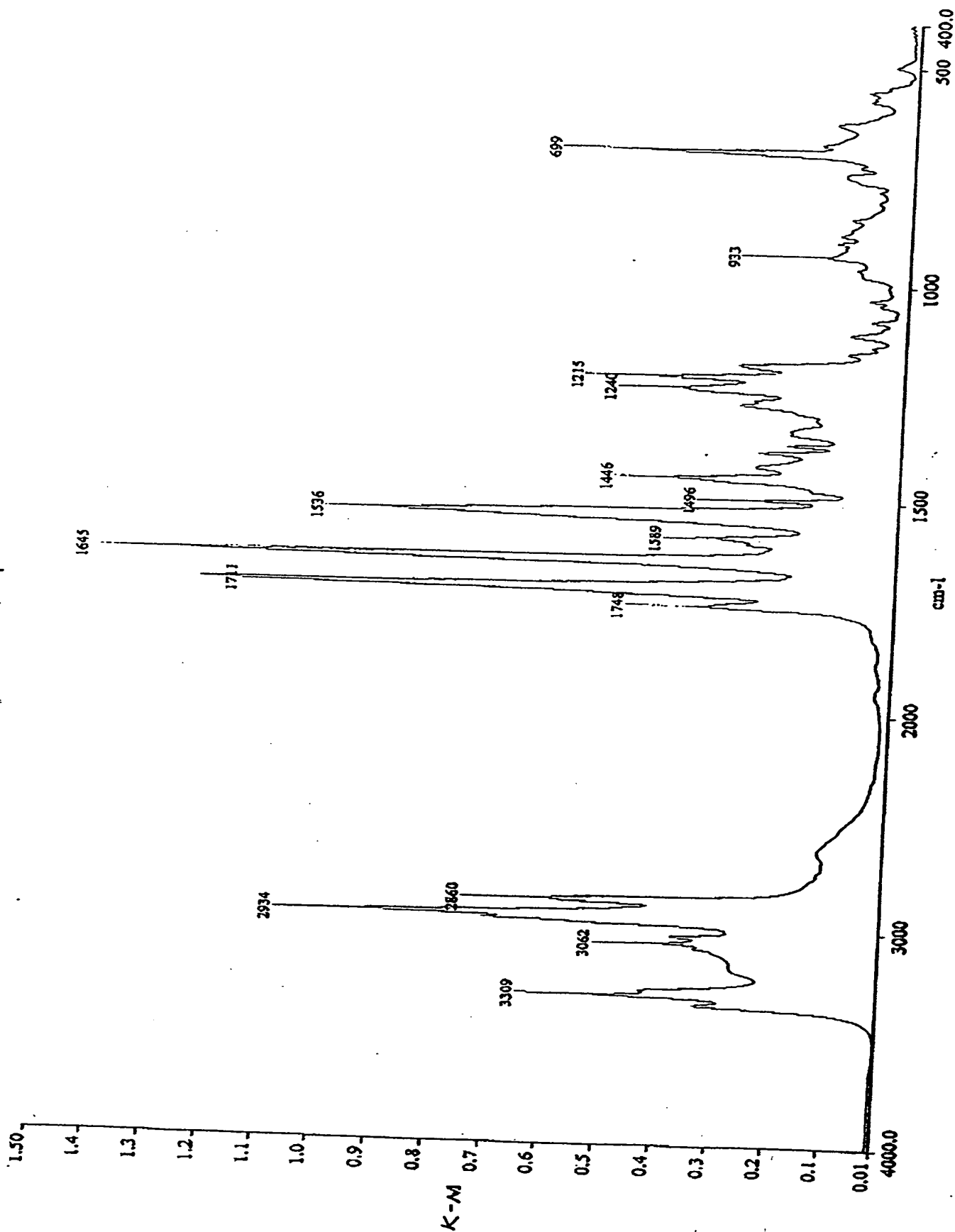
FIGURE 29

Form 7



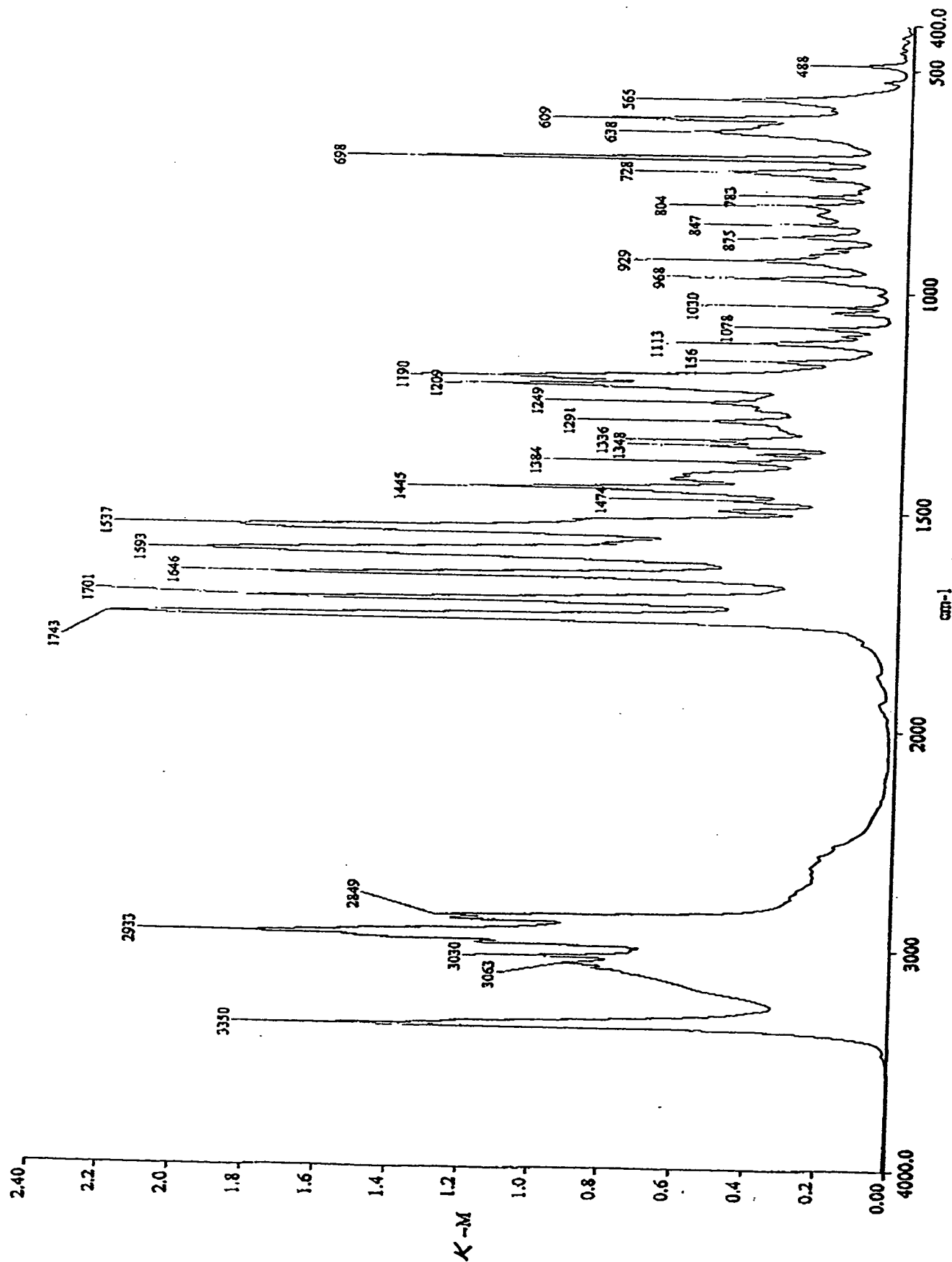
-DRIFT, 4000-400 CM-1, 16 scans, Resolution: 4.00cm-1

FIGURE 30  
Form P



DRIFT, 4000-400 CM-1, 16 scans, Resolution: 4.00cm-1

FIGURE 30  
For U



- DRIFT, 4000-400cm-1, 18 scans, resolution: 4.0cm-1



32  
Figure 32 - Nateglinide Form Z

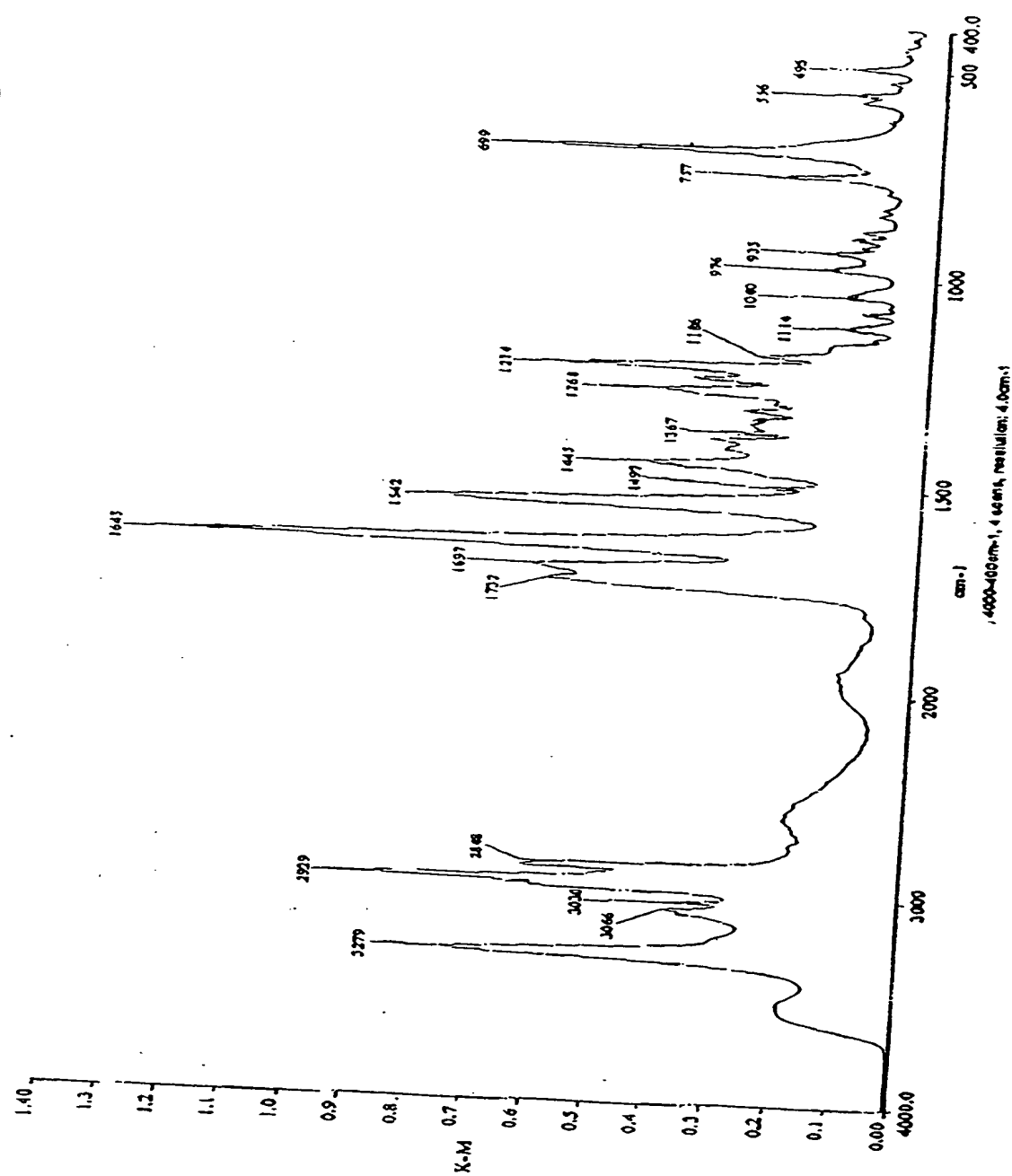
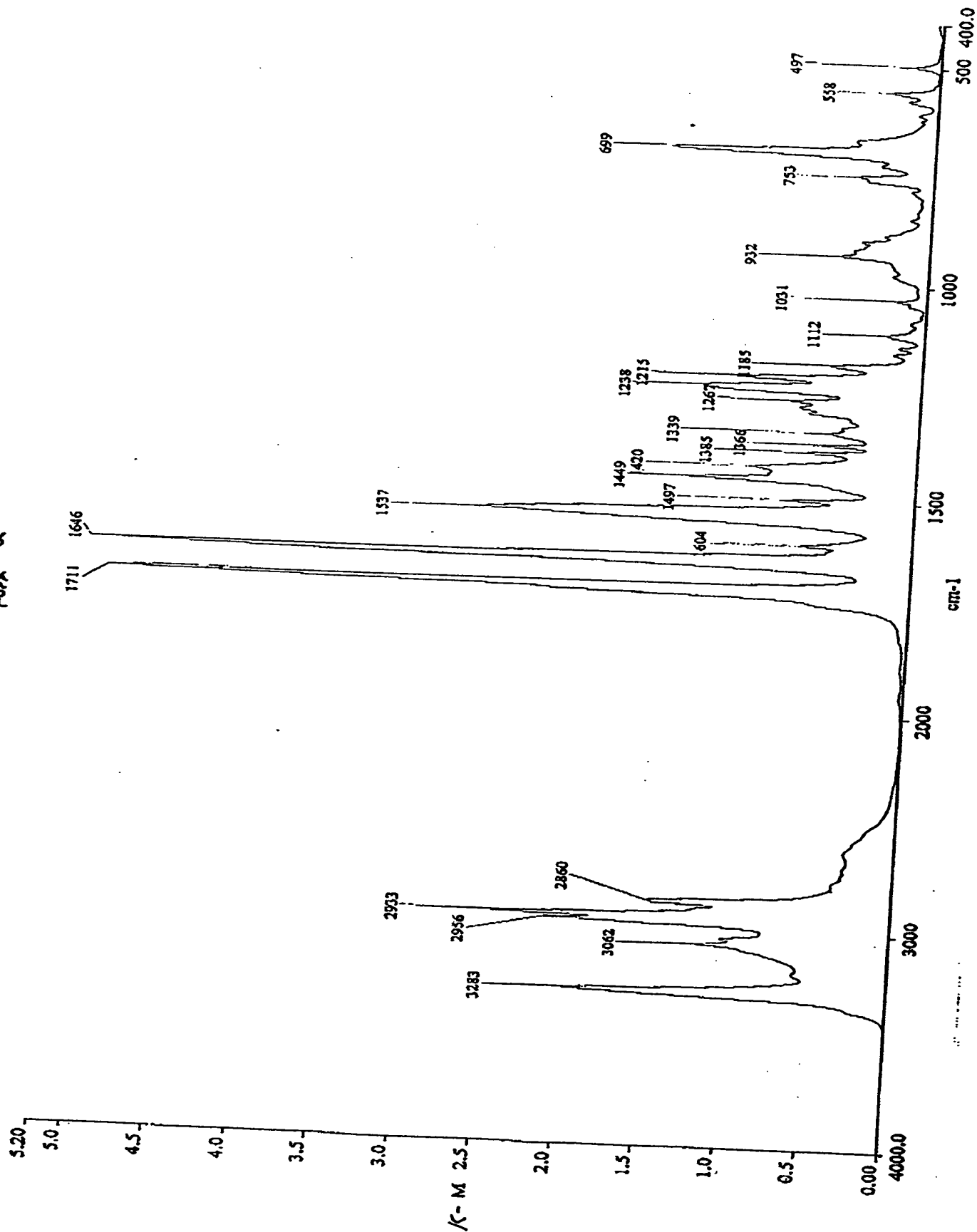
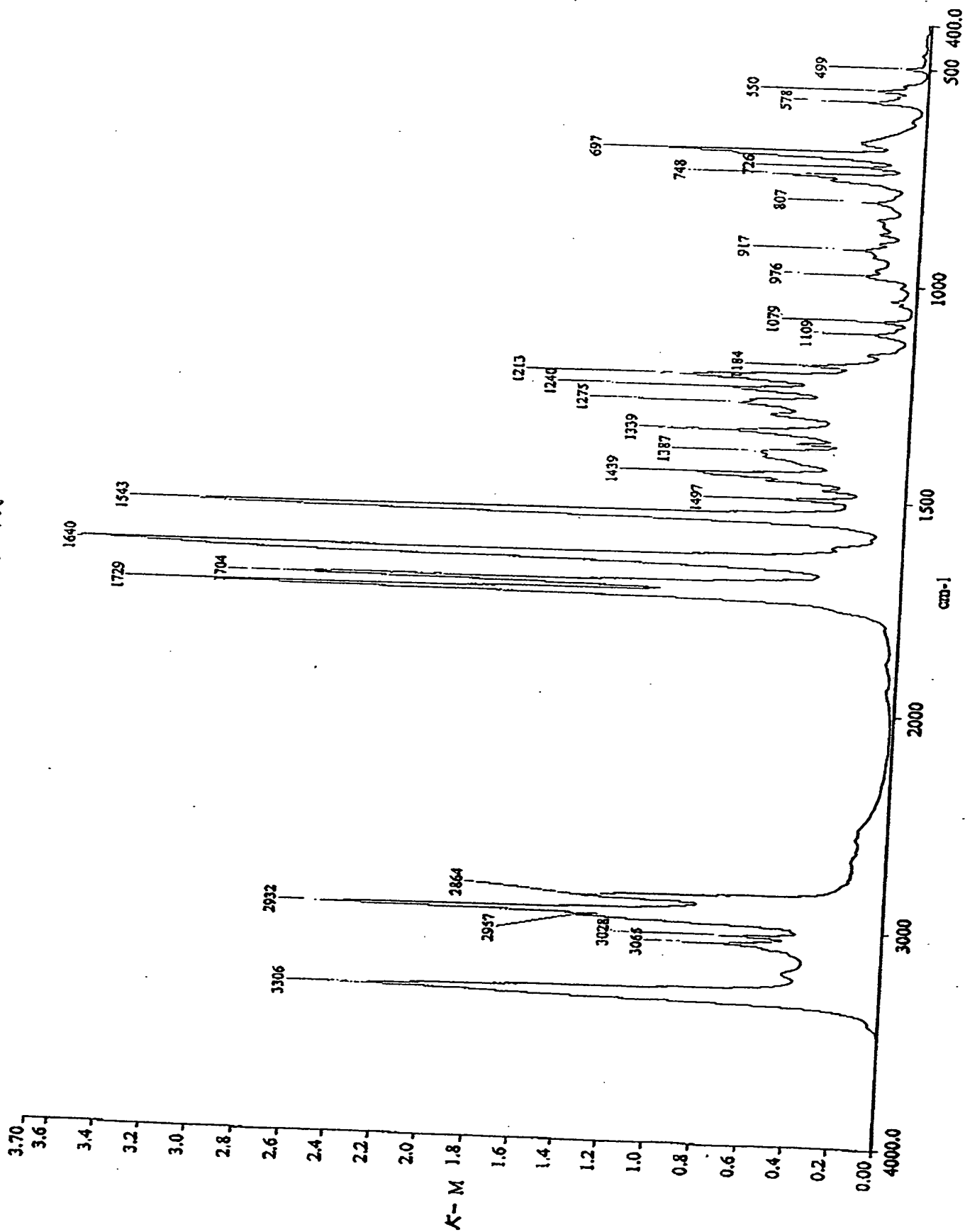


FIGURE 33  
Form α



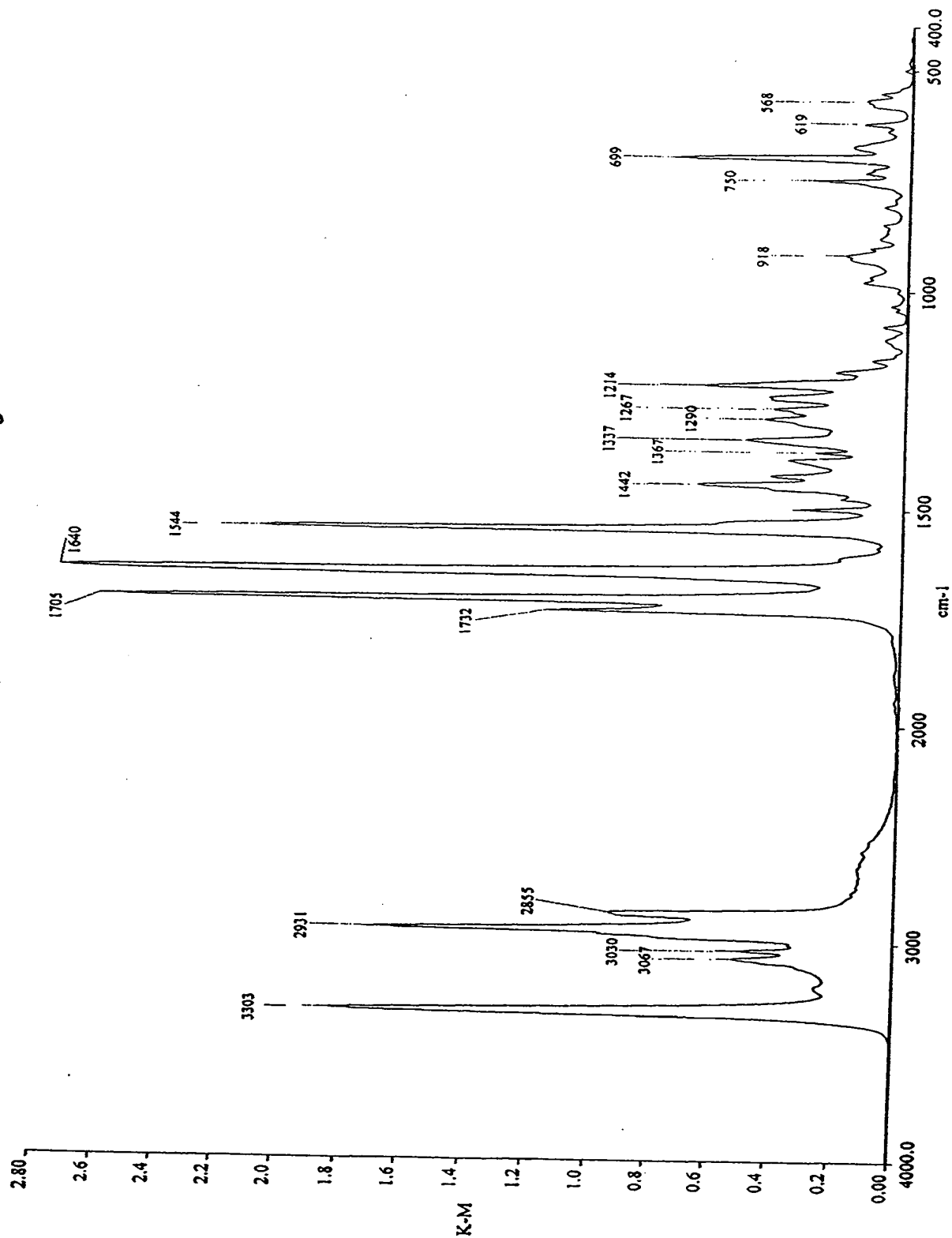
DRIFT, 4000-400 cm<sup>-1</sup>, 16 scans, Resolution: 4.00 cm<sup>-1</sup>

FIGURE 34 Form delta



DRIFT, 4000-400cm⁻¹, 16 scans, resolution: 4.0cm⁻¹

FIGURE 35 - form



DRIFT, 4000-400CM-1, 16 SCANS RESOLUTION: 4.0CM-1

form (O)

FIGURE 36 Form A

Method: 30-250C, 10C/min, 40ml/min N2  
30.0-250.0°C 10.00°C/min N2, 40.0 ml/min

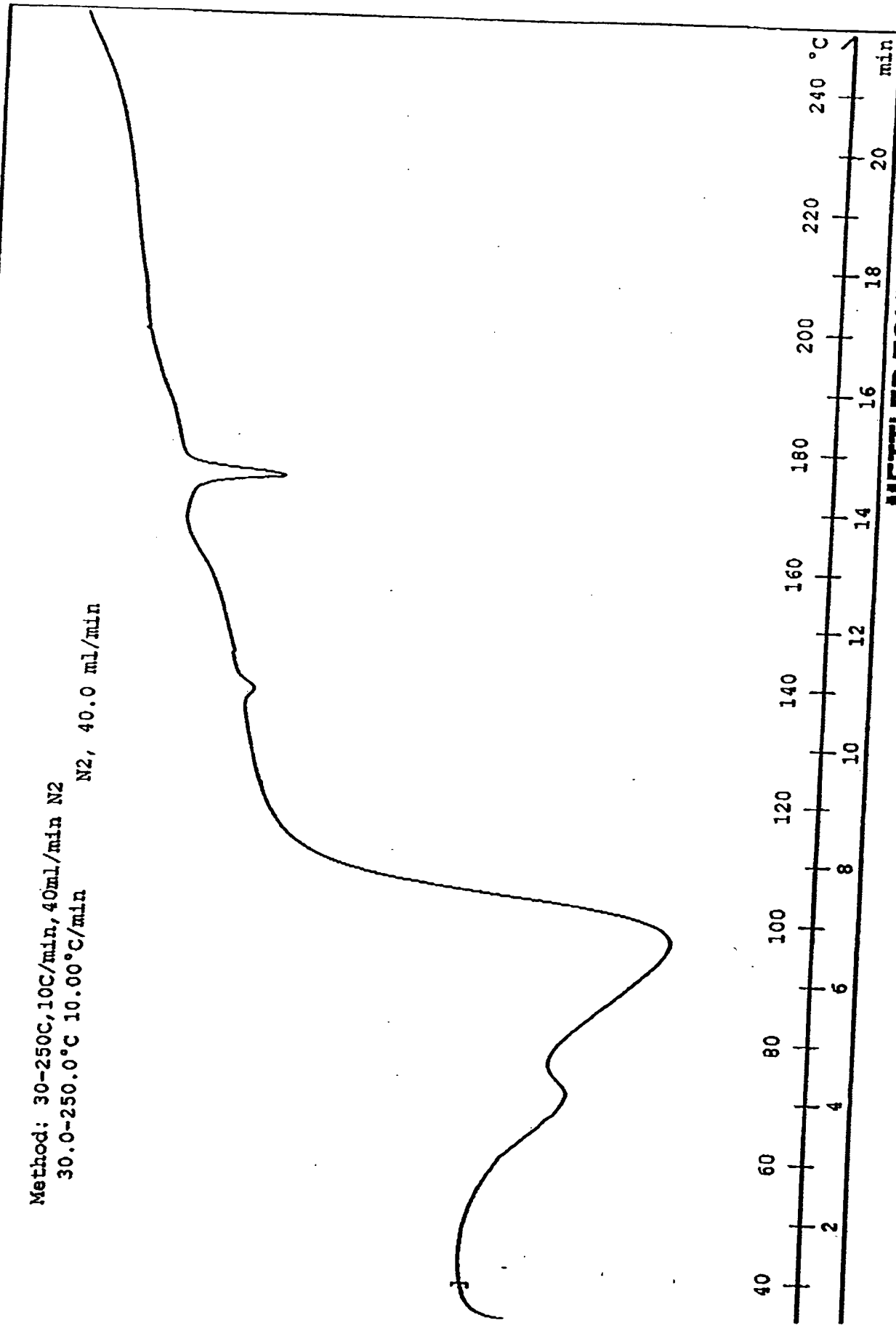
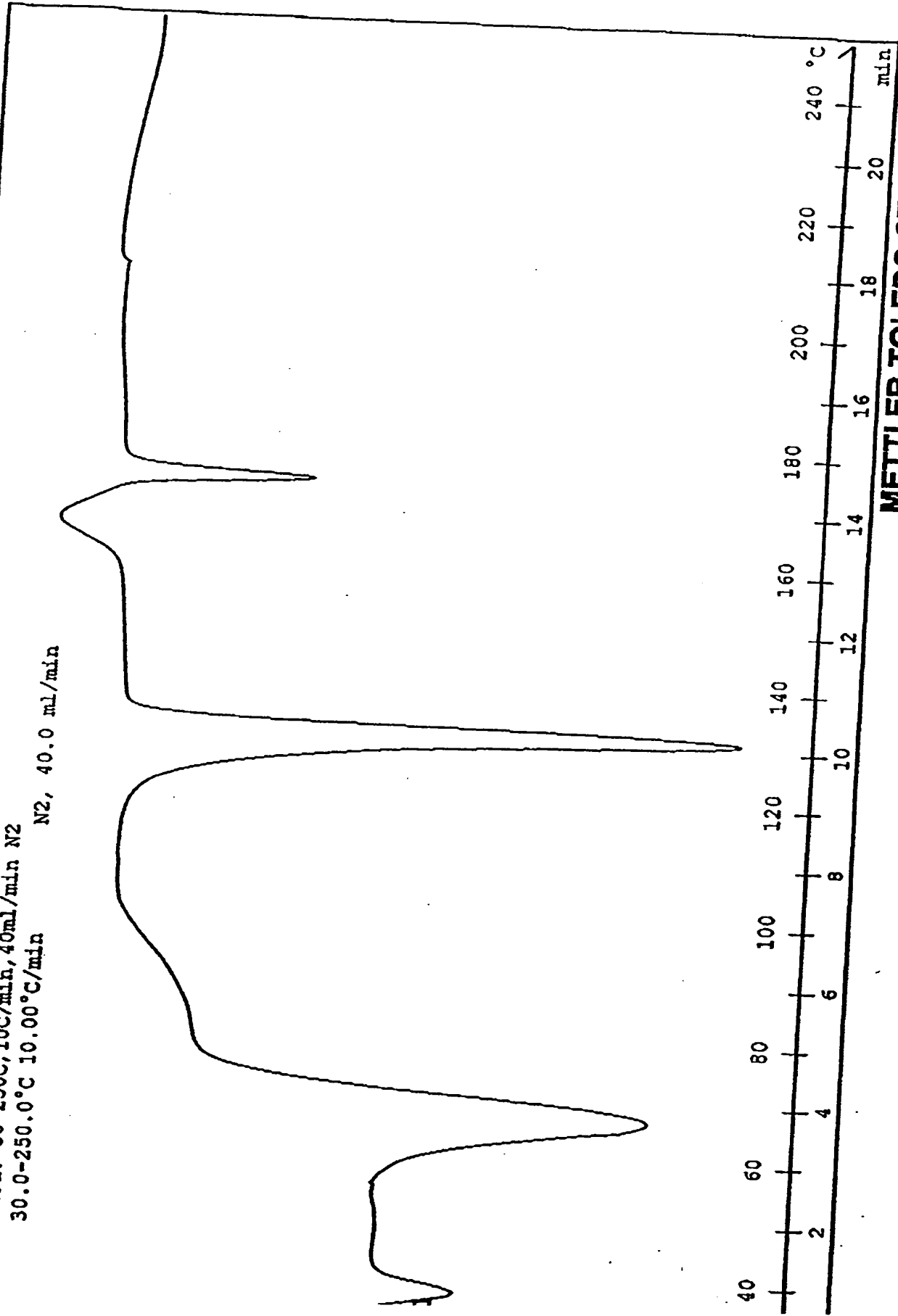


FIGURE 37

Form D

Method: 30-250°C, 10°C/min, 40ml/min N2  
30.0-250.0°C 10.00°C/min

N2, 40.0 ml/min



METTLER TOLEDO STAR® System

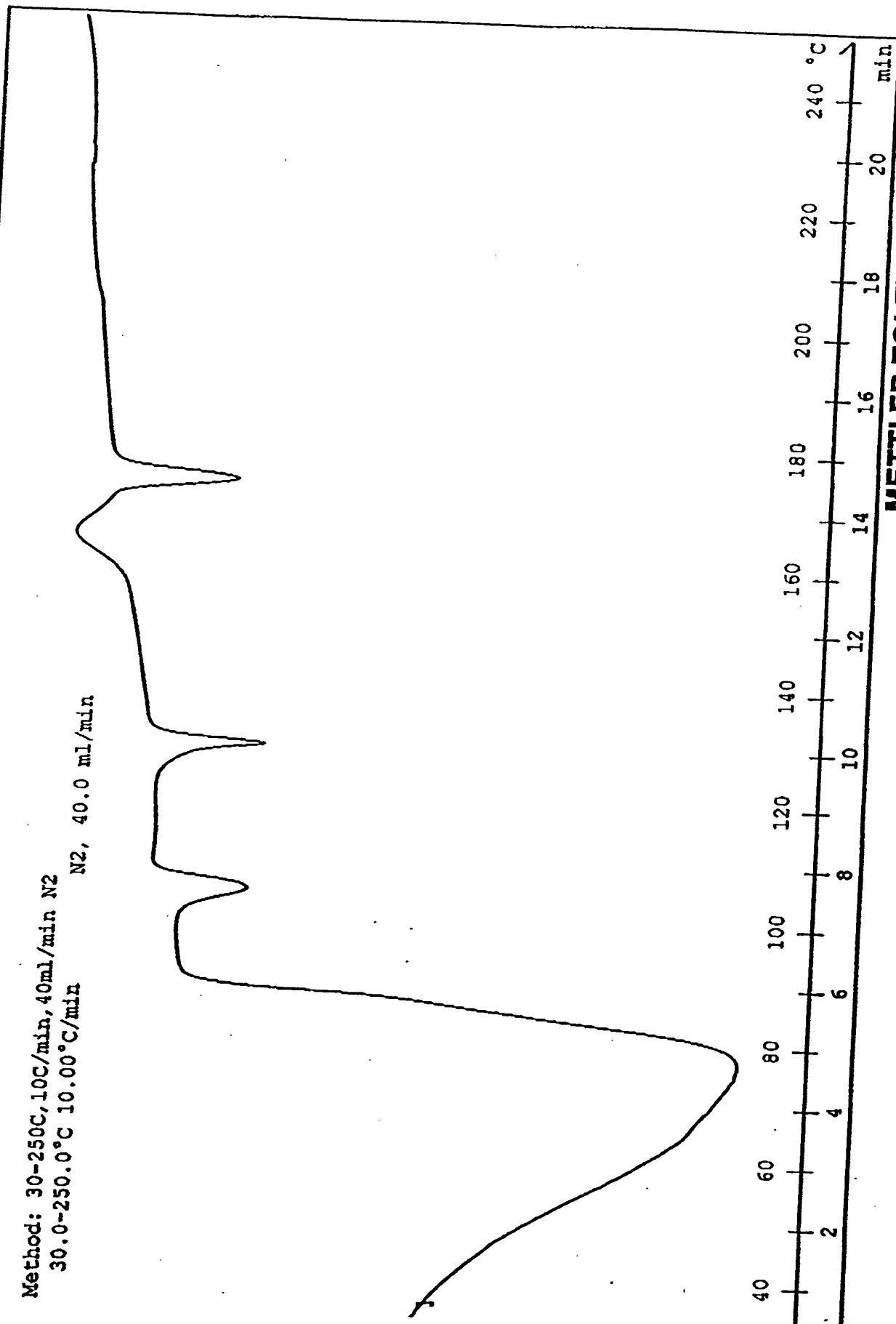
FIGURE 36

Form E

Method: 30-250°C, 10°C/min, 40ml/min N2

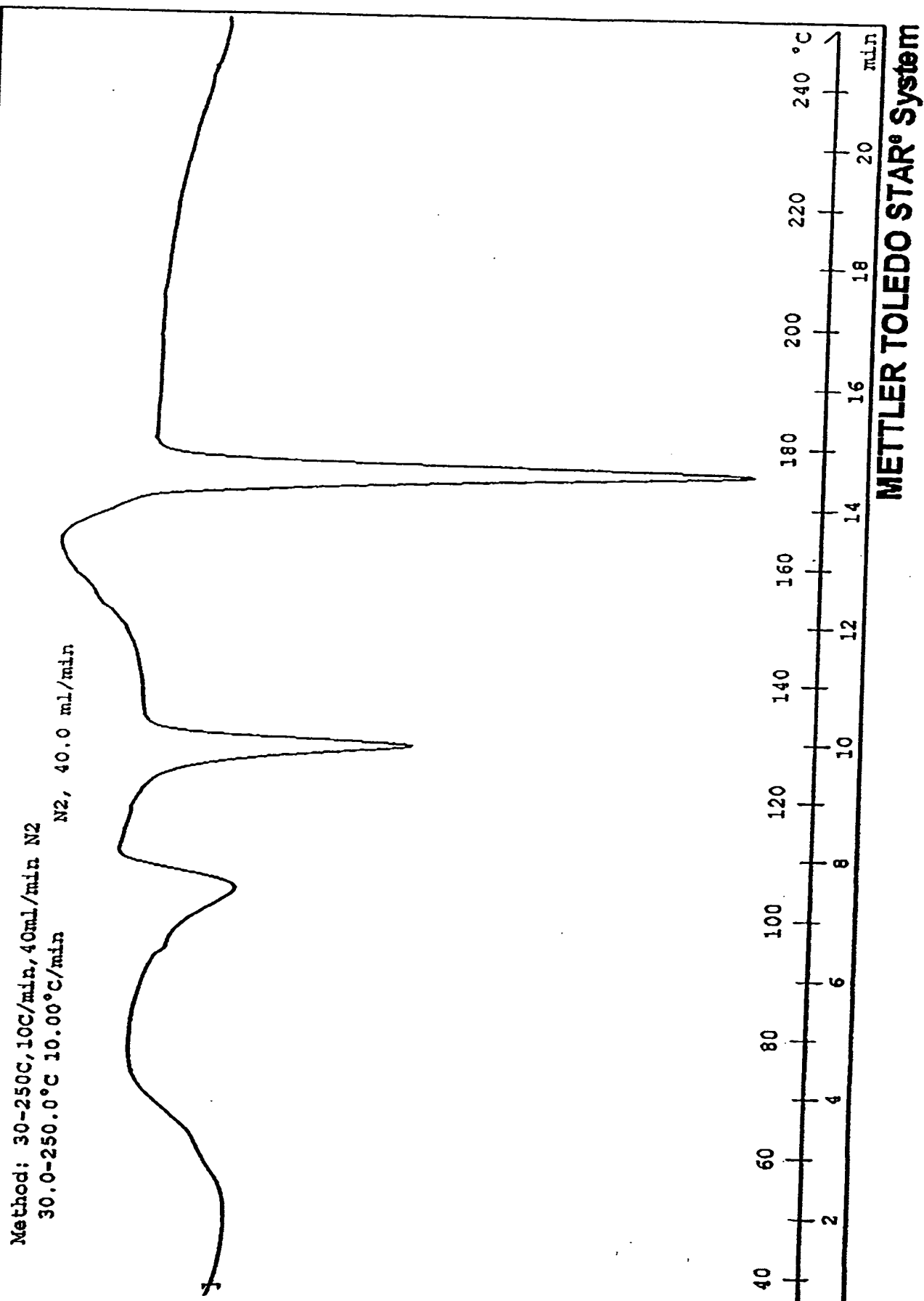
30.0-250.0°C 10.00°C/min

N2, 40.0 ml/min



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FIGURE 1

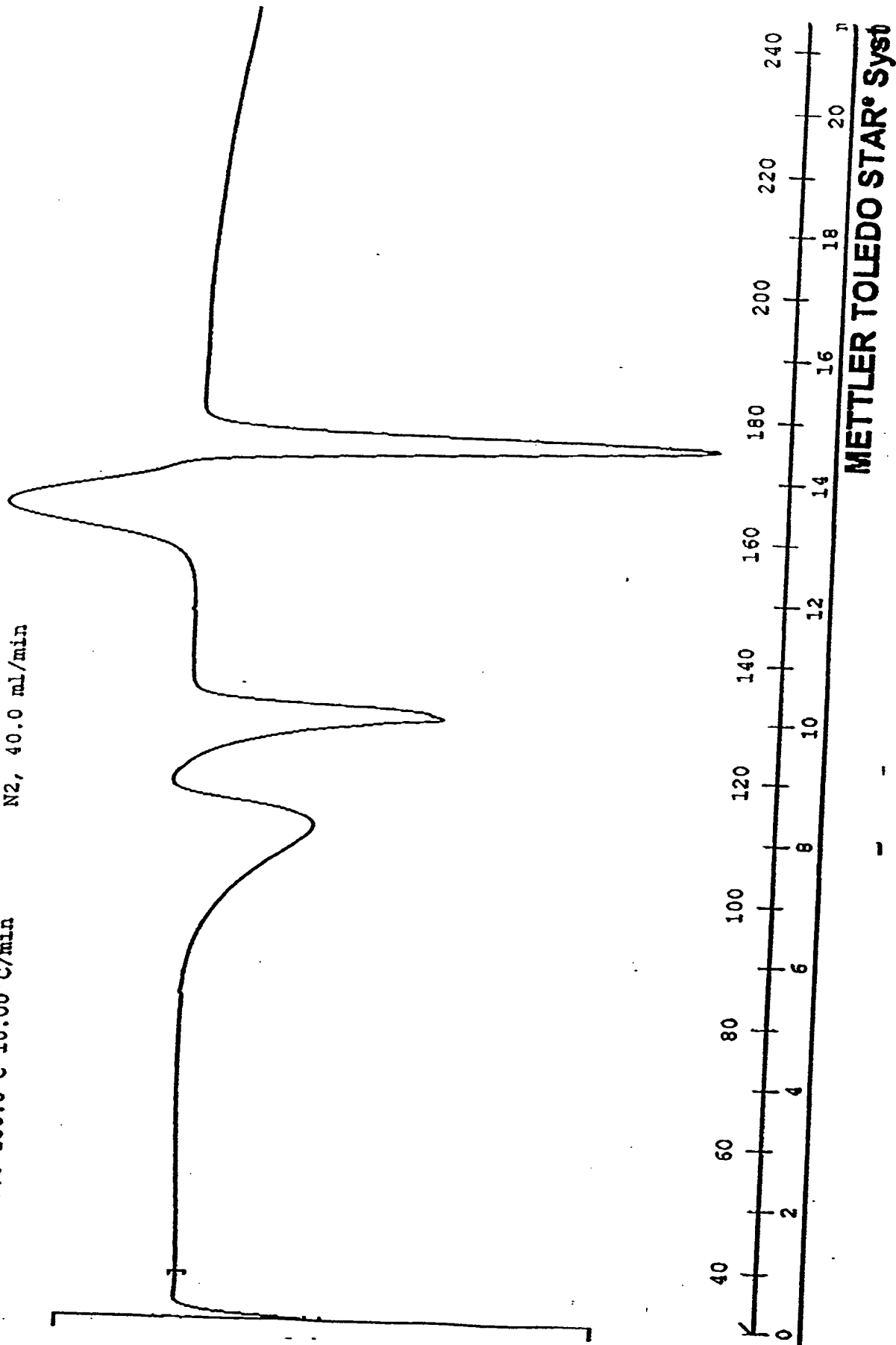




40  
FIGURE 88

IXO

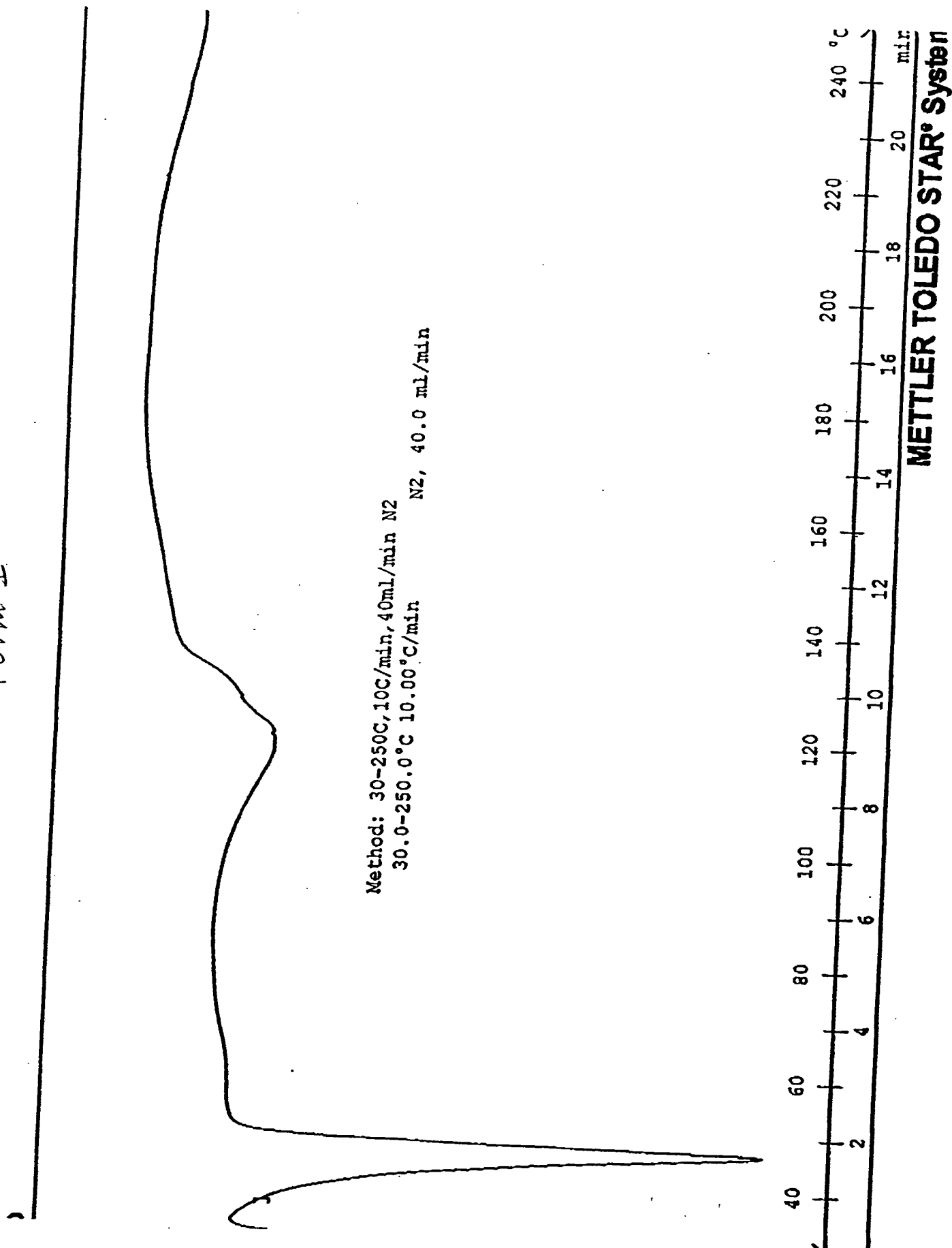
Method: 30-250C, 10C/min, 40ml/min N2  
30.0-250.0°C 10.00°C/min N2, 40.0 ml/min



METTLER TOLEDO STAR® Syst

FIGURE 2041

Form I



42  
FIGURE  
Form J

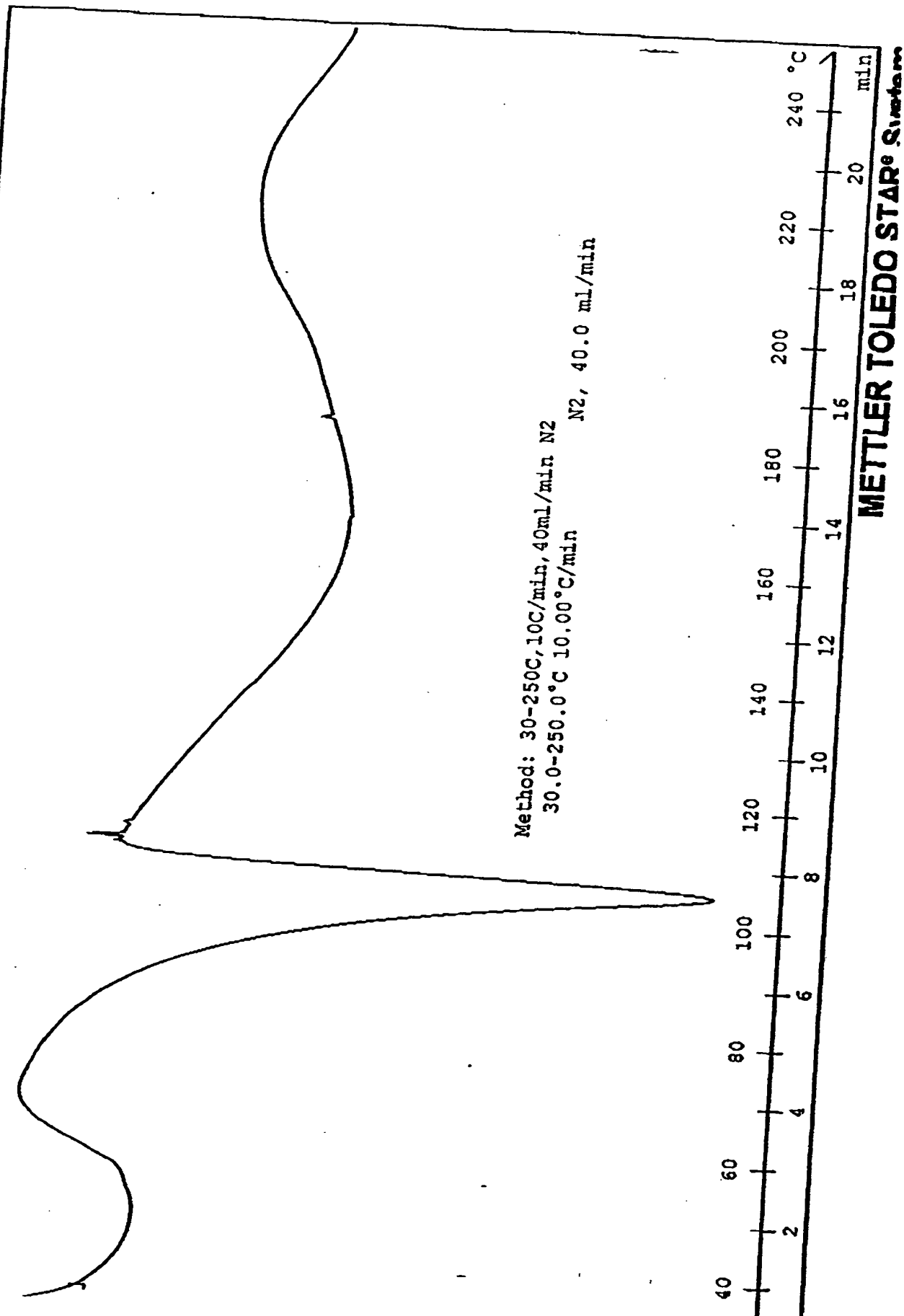
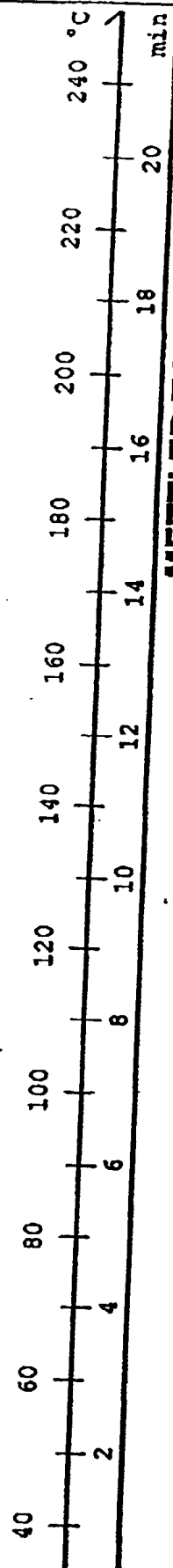


FIGURE 43  
Form K

Method: 30-250°C, 10°C/min, 40 ml/min N<sub>2</sub>  
30.0-250.0°C 10.00°C/min N<sub>2</sub>, 40.0 ml/min



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FIGURE 42 4/4  
Form L

Method: 30-250°C, 10°C/min, 40ml/min N2  
30.0-250.0°C 10.00°C/min  
N2, 40.0 ml/min

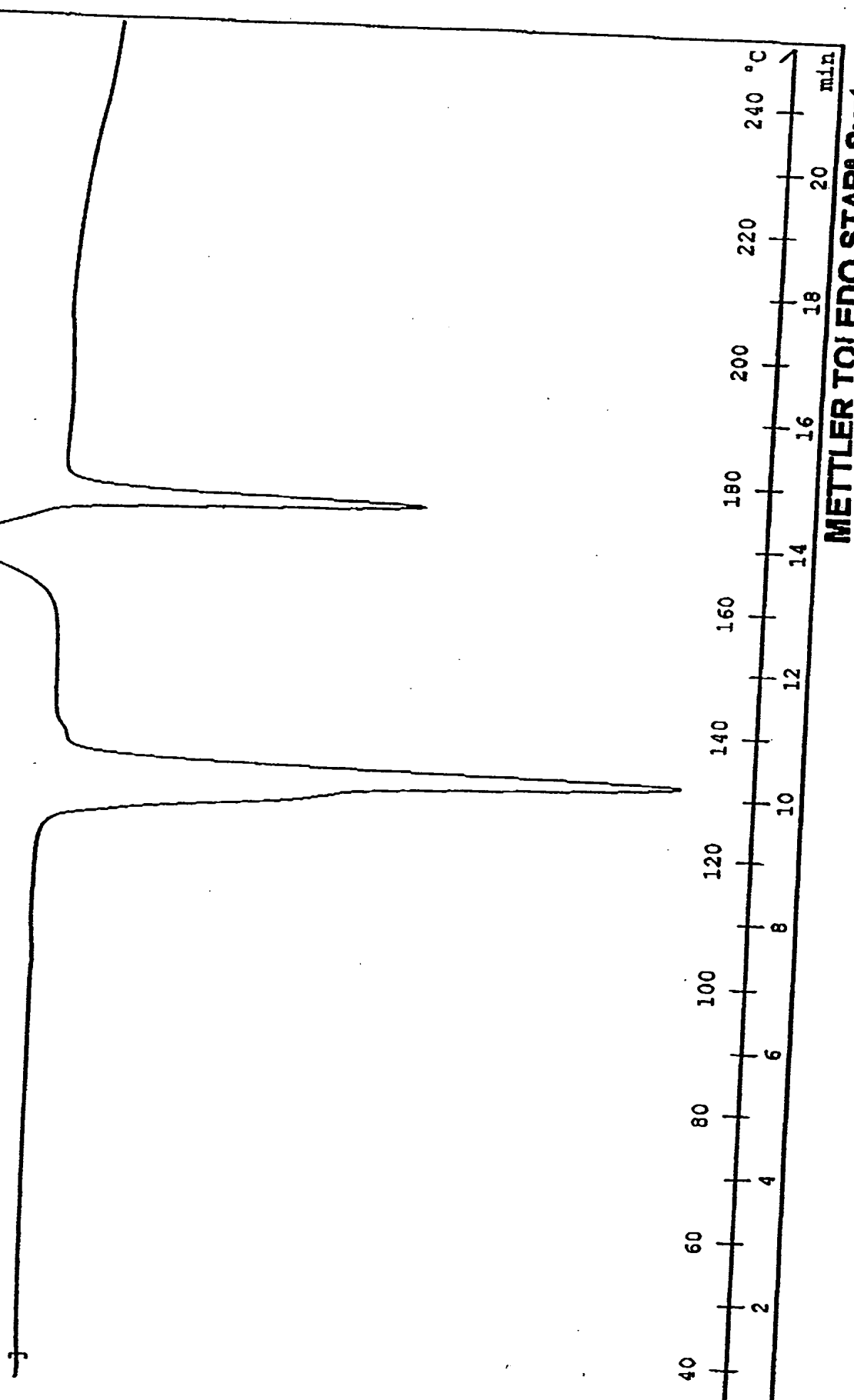
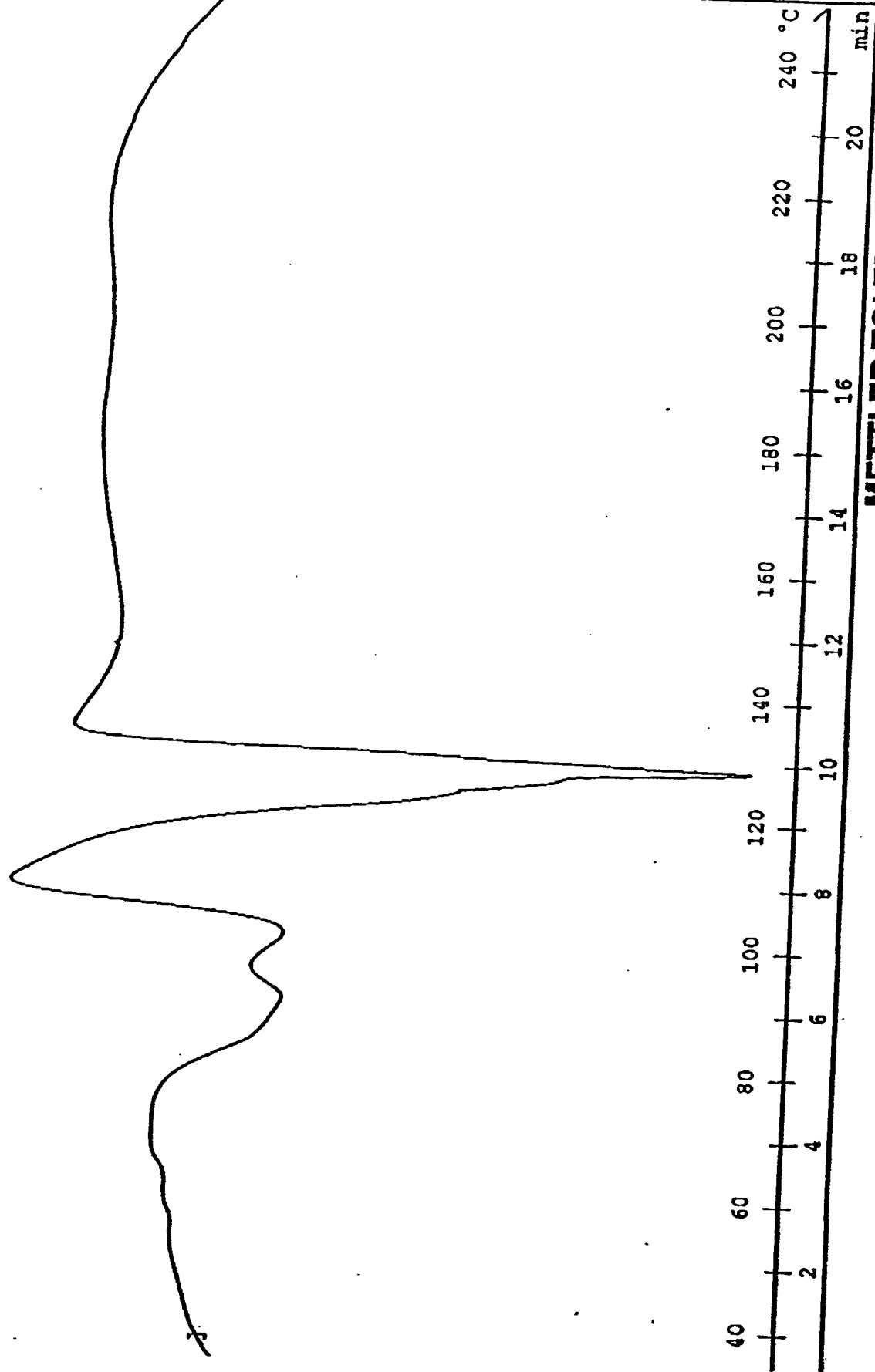


FIGURE 45  
Form M

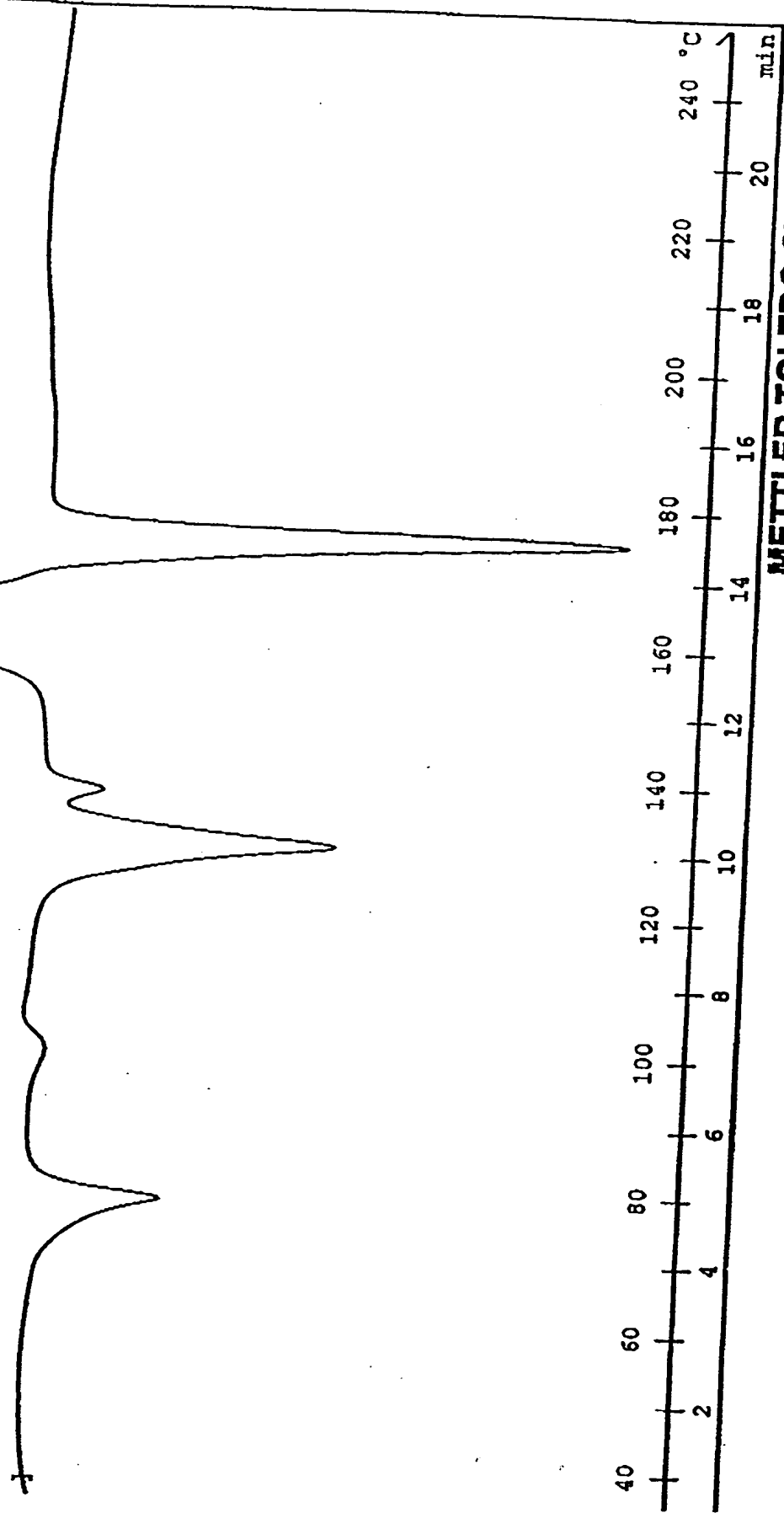
Method: 30-250°C, 10°C/min, 40ml/min N2  
30.0-250.0°C 10.00°C/min  
N2, 40.0 ml/min



METTLER TOLEDO STAR® System

FIGURE 44 46  
Form N

Method: 30-250C, 10C/min, 40ml/min N2  
30.0-250.0°C 10.00°C/min  
N2, 40.0 ml/min

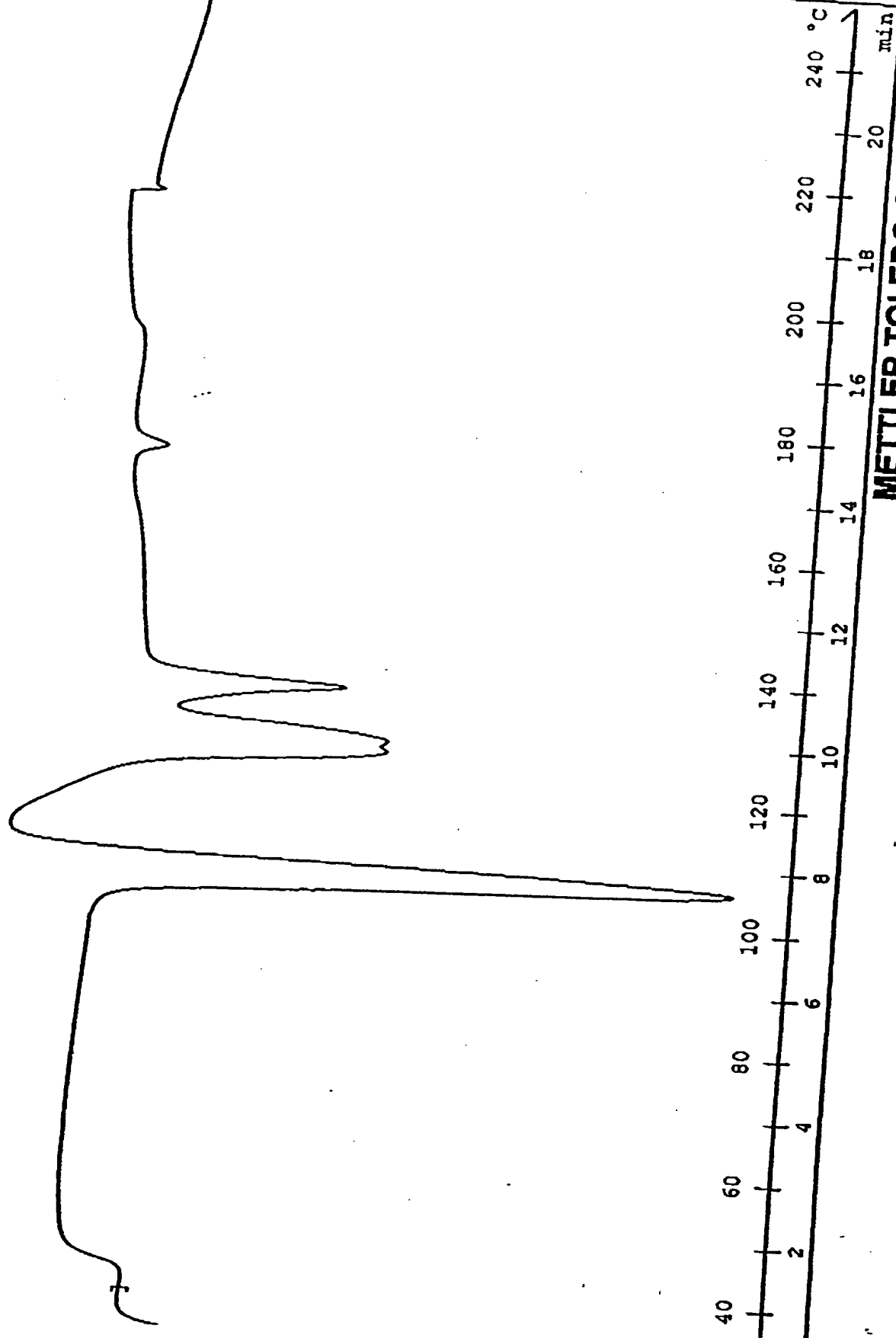


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FIGURE #3 47  
Form G

Method: 30-250°C, 10°C/min, 40 mL/min N2  
30.0-250.0°C 10.00°C/min

N2, 40.0 mL/min



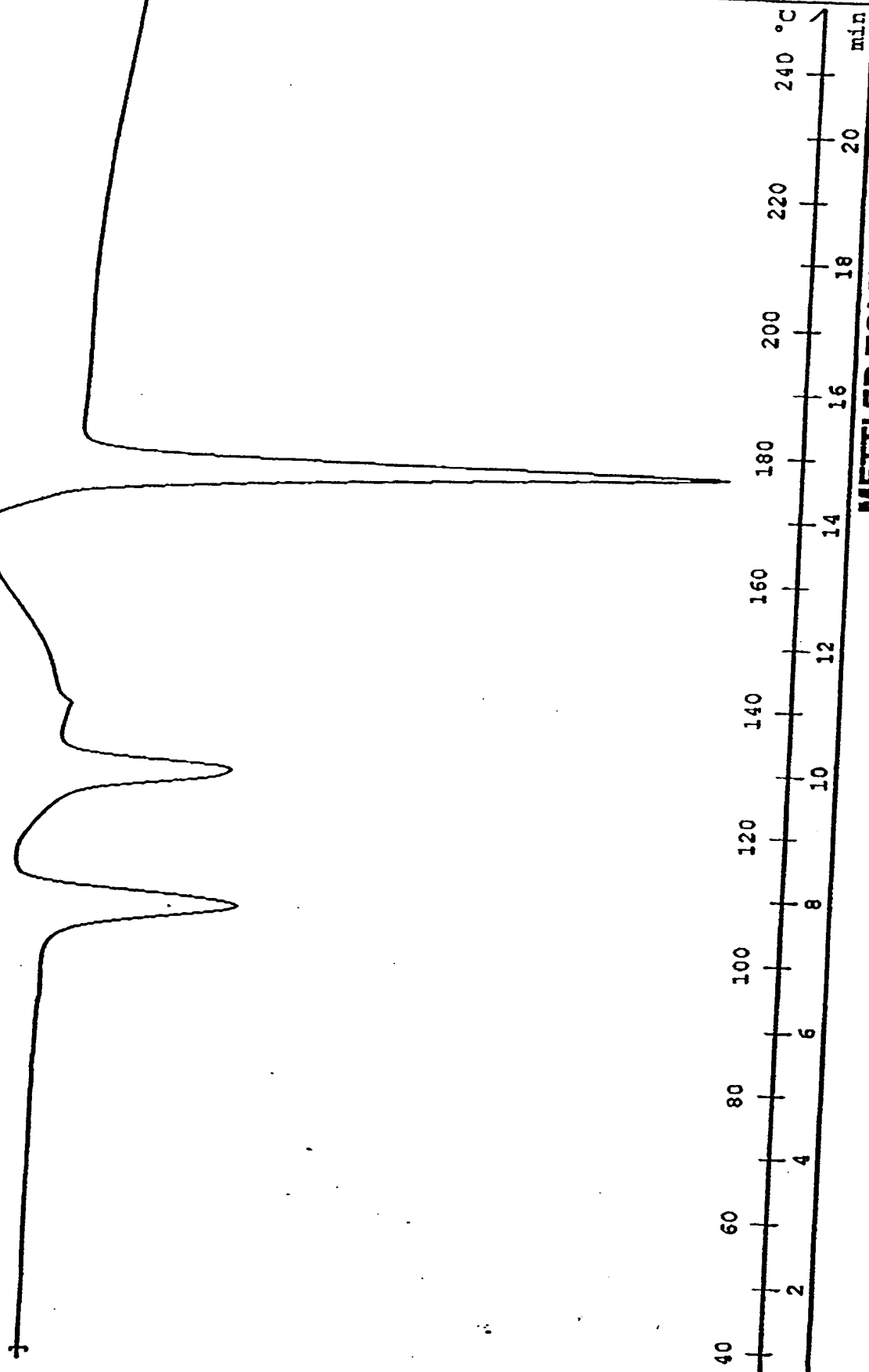
METTLER TOLEDO STAD® G



Fig. 48  
Form P

Method: 30-250°C, 10°C/min, 40ml/min N<sub>2</sub>  
30.0-250.0°C 10.00°C/min

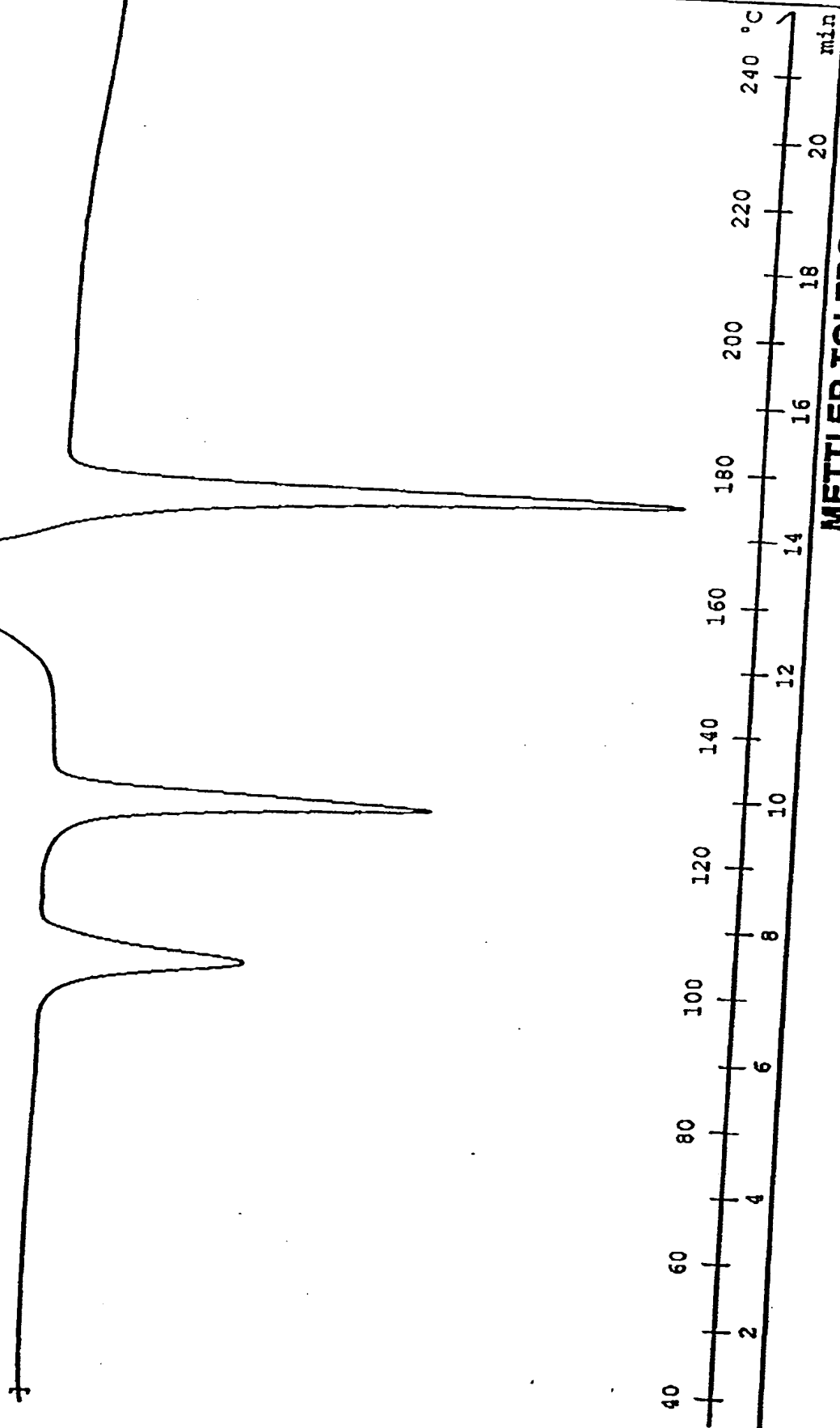
N<sub>2</sub>, 40.0 ml/min



METTLER TOLEDO STAR® System

FIGURE 47 49  
Form Q

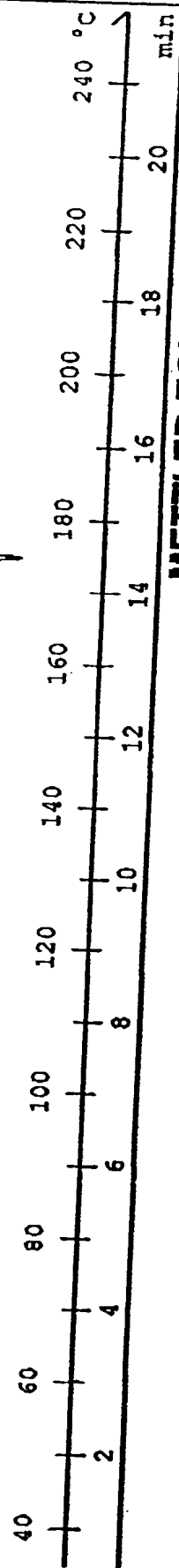
Method: 30-250°C, 10°C/min, 40ml/min N2  
30.0-250.0°C 10.00°C/min N2, 40.0 ml/min



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FIGURE 48-50  
Form T

Method: 30-250°C, 10°C/min, 40ml/min N<sub>2</sub>  
30.0-250.0°C 10.00°C/min N<sub>2</sub>, 40.0 ml/min



METTLER TOLEDO STAR® System

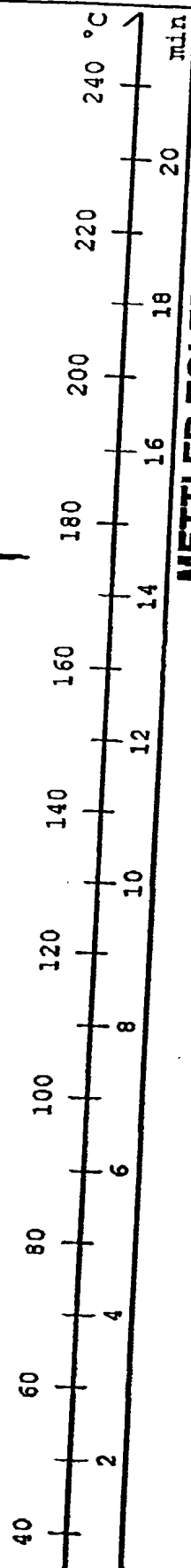
FIGURE 49. 51

Form U

Method: 30-250C, 10C/min, 40ml/min N2  
30.0-250.0°C 10.00°C/min

N2, 40.0 ml/min

1



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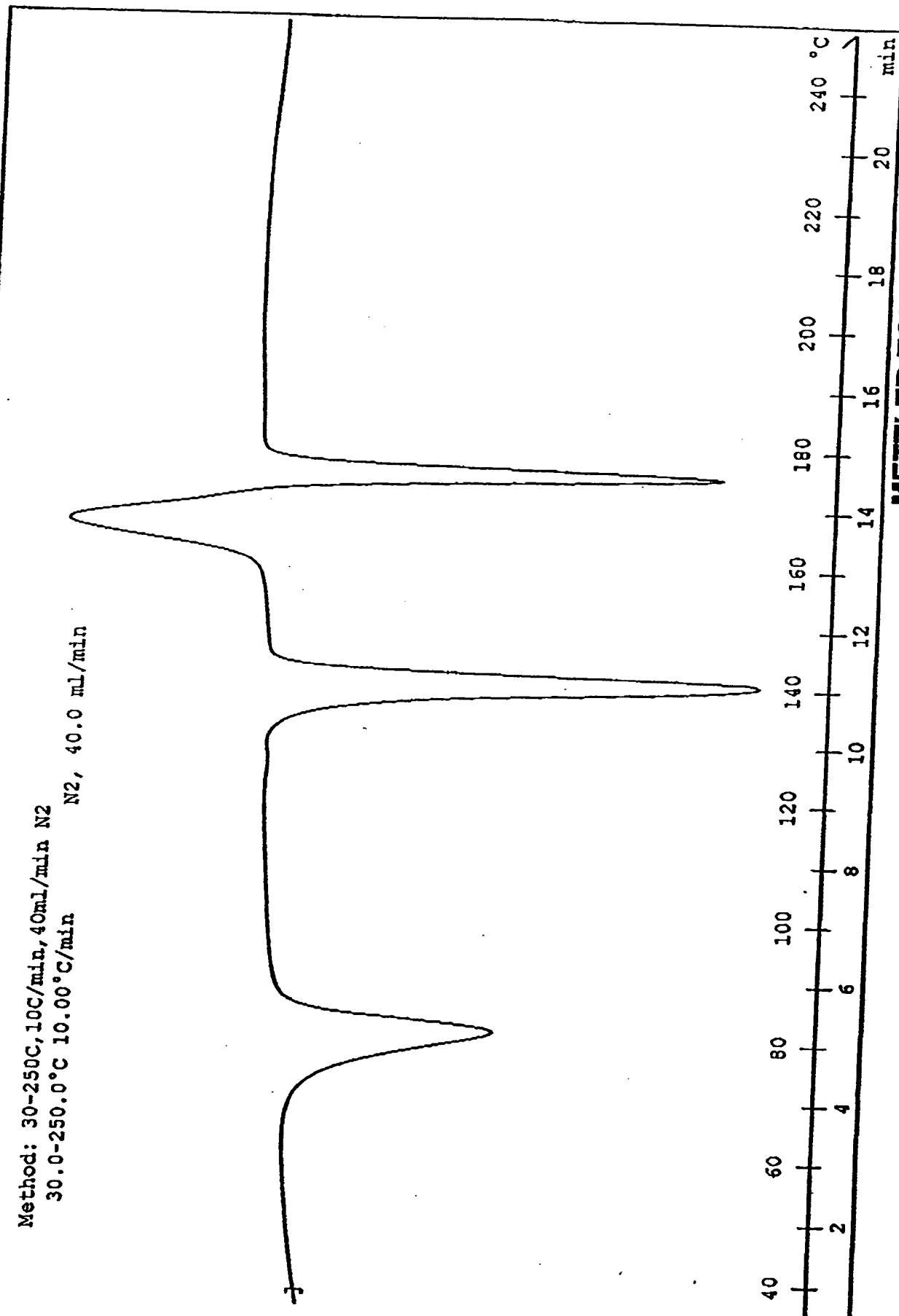
FIGURE 5052

Form V

Method: 30-250°C, 10°C/min, 40 mL/min N<sub>2</sub>

30.0-250.0°C 10.00°C/min

N<sub>2</sub>, 40.0 mL/min

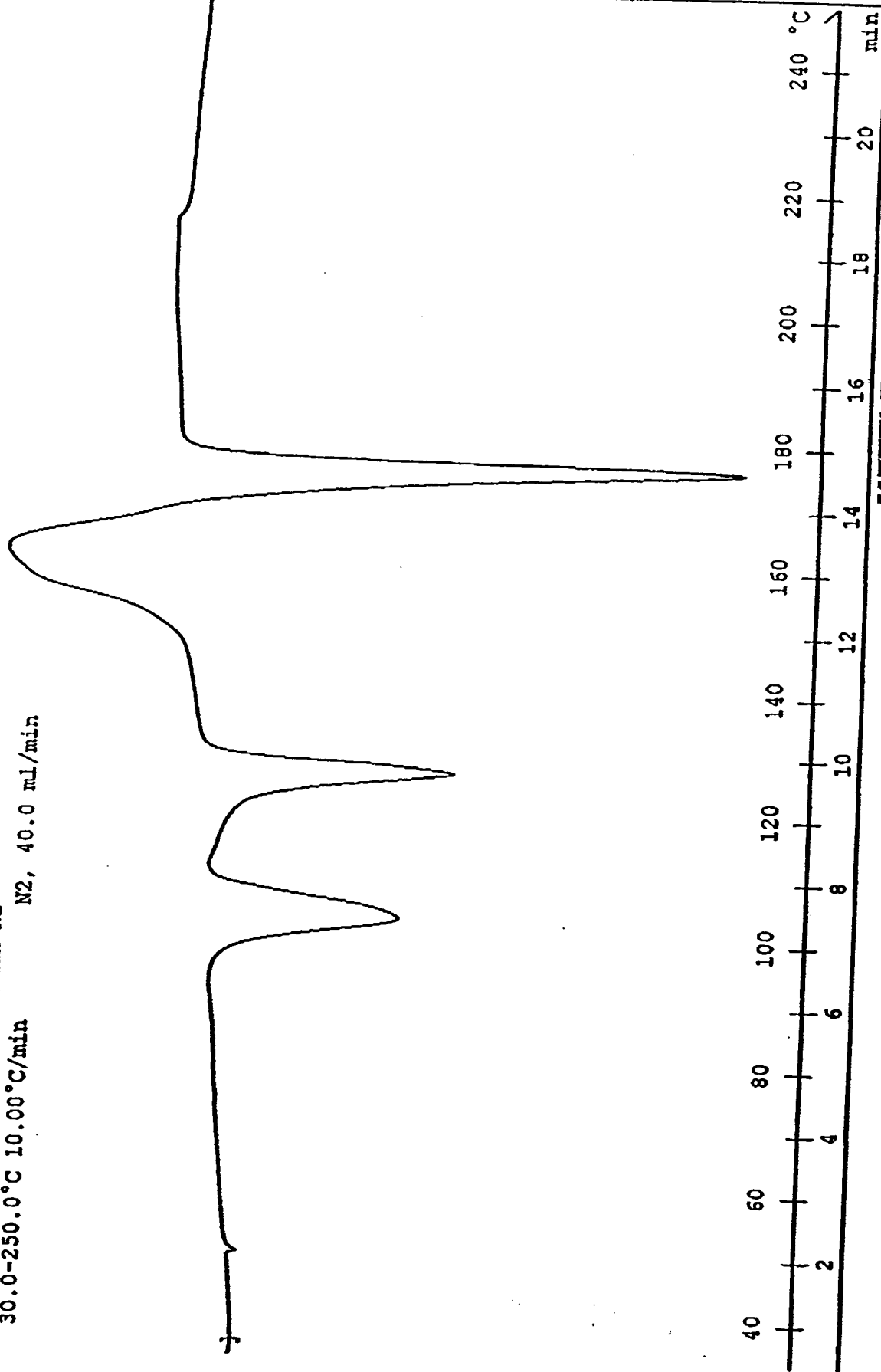


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FIGURE 52-53

Form Y (chloroform solvent)

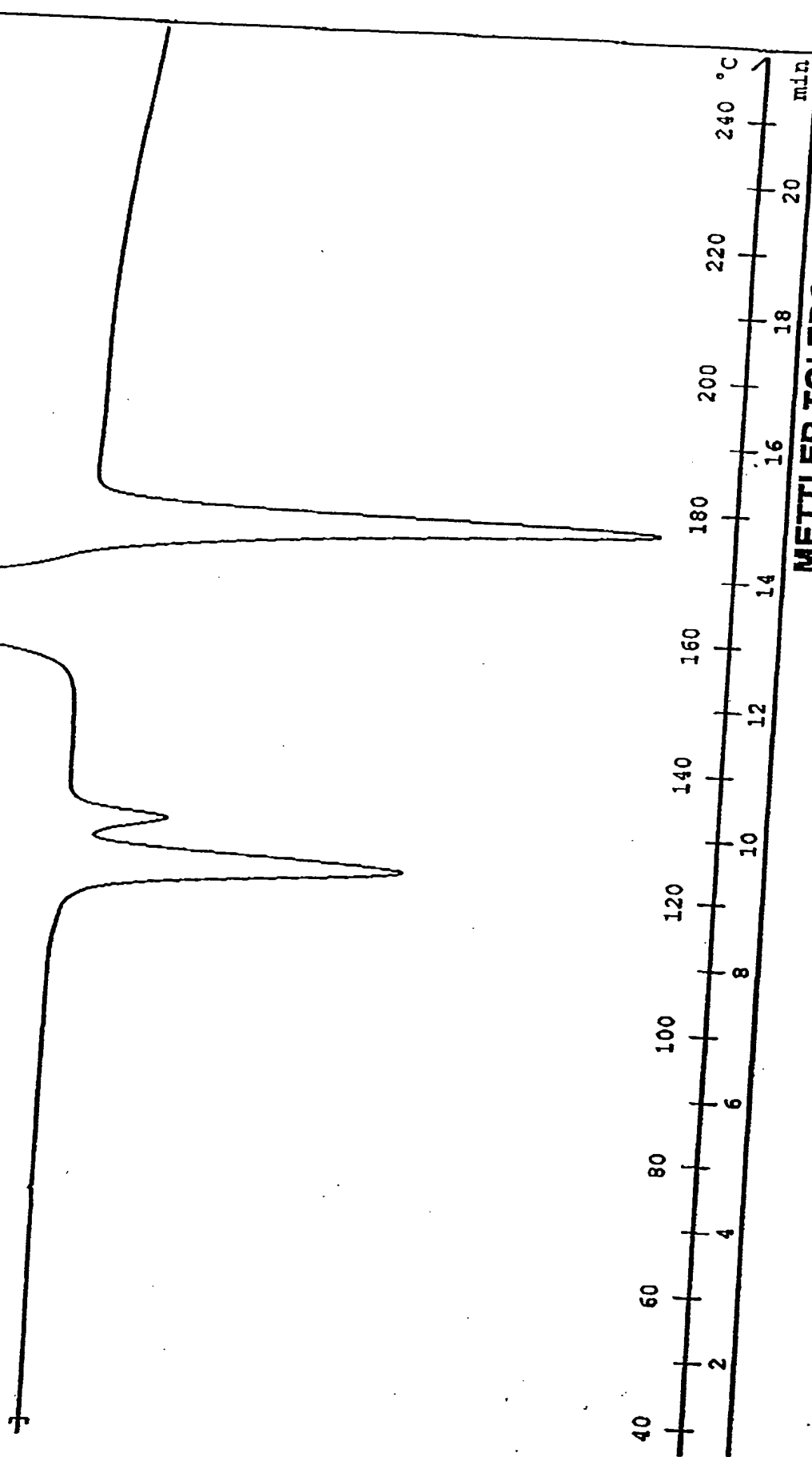
Method: 30-250°C, 10°C/min, 40ml/min N2  
30.0-250.0°C 10.00°C/min  
N2, 40.0 ml/min



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Figure 5 *4*  
Y (dichloromethane solvate)

Method: 30-250°C, 10°C/min, 40ml/min N<sub>2</sub>  
30.0-250.0°C 10.00°C/min N<sub>2</sub>, 40.0 ml/min



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55  
Figure 27 - Nataglinde Form Z

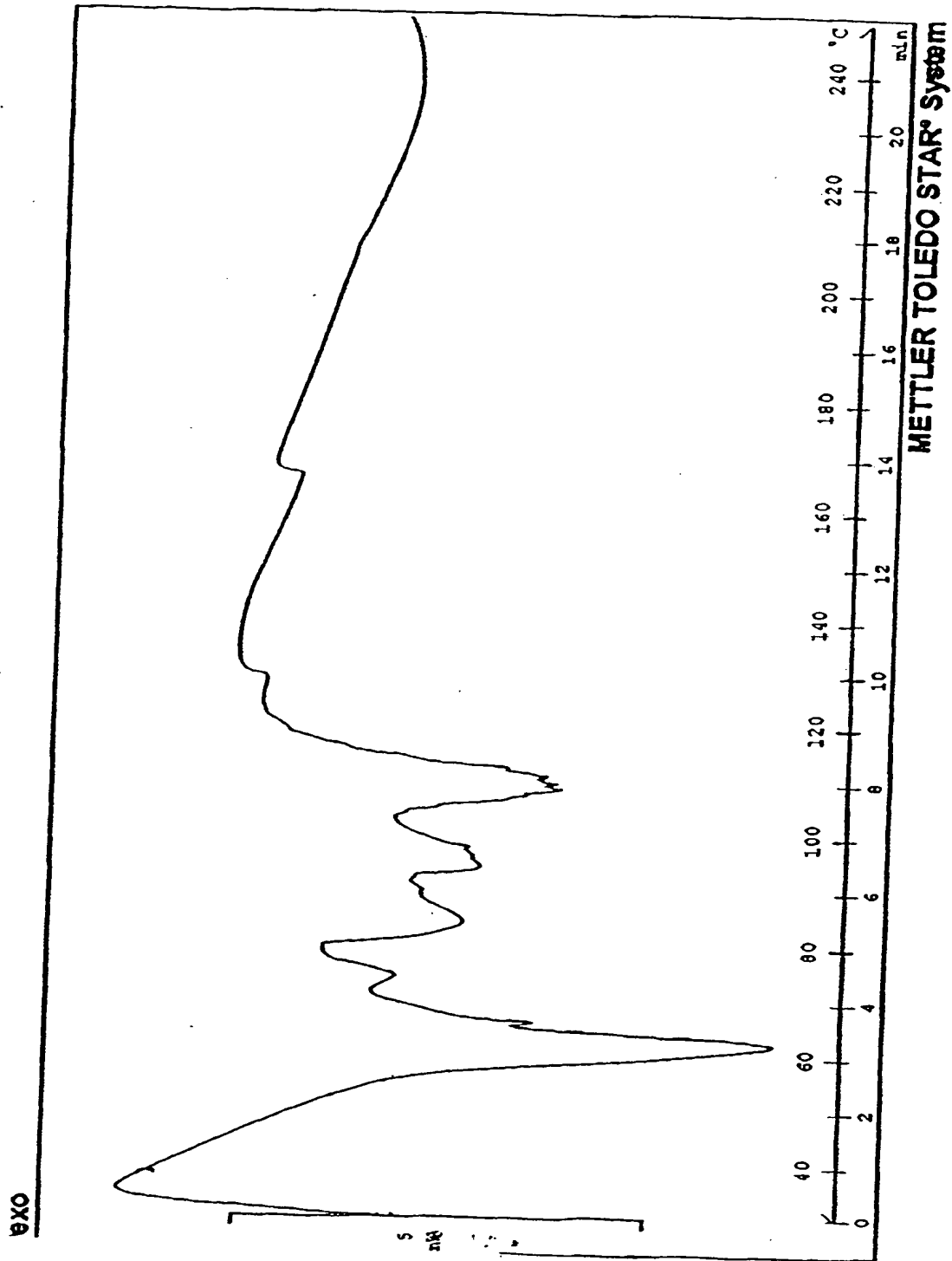
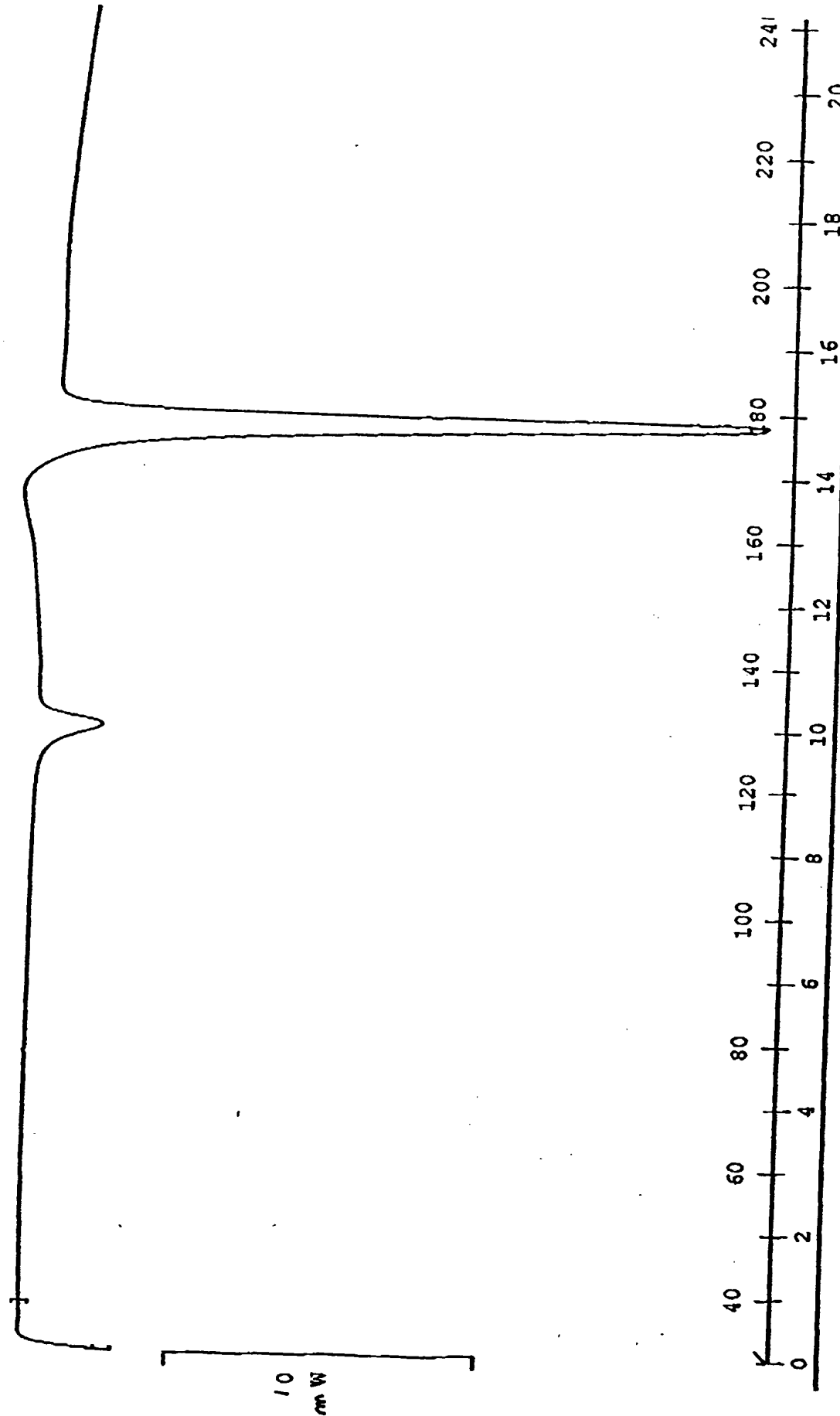




FIGURE 51-56  
Form  $\alpha$

1X0

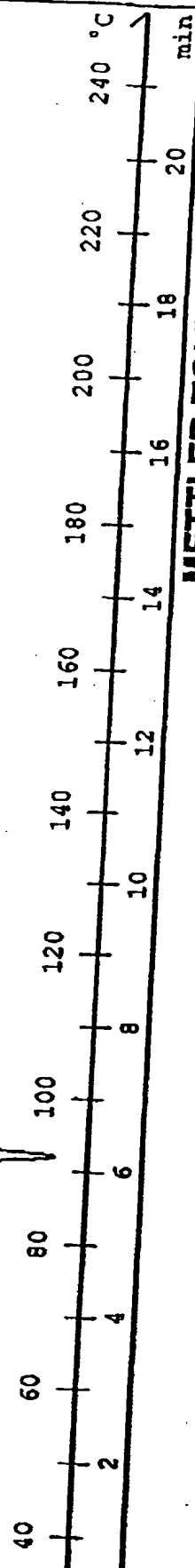
Method: 30-250°C, 10°C/min, 40ml/min N<sub>2</sub>  
30.0-250.0°C 10.00°C/min N<sub>2</sub>, 40.0 ml/min



METTLER TOLEDO STAR<sup>®</sup> SY

FLAME 57  
Form Beta

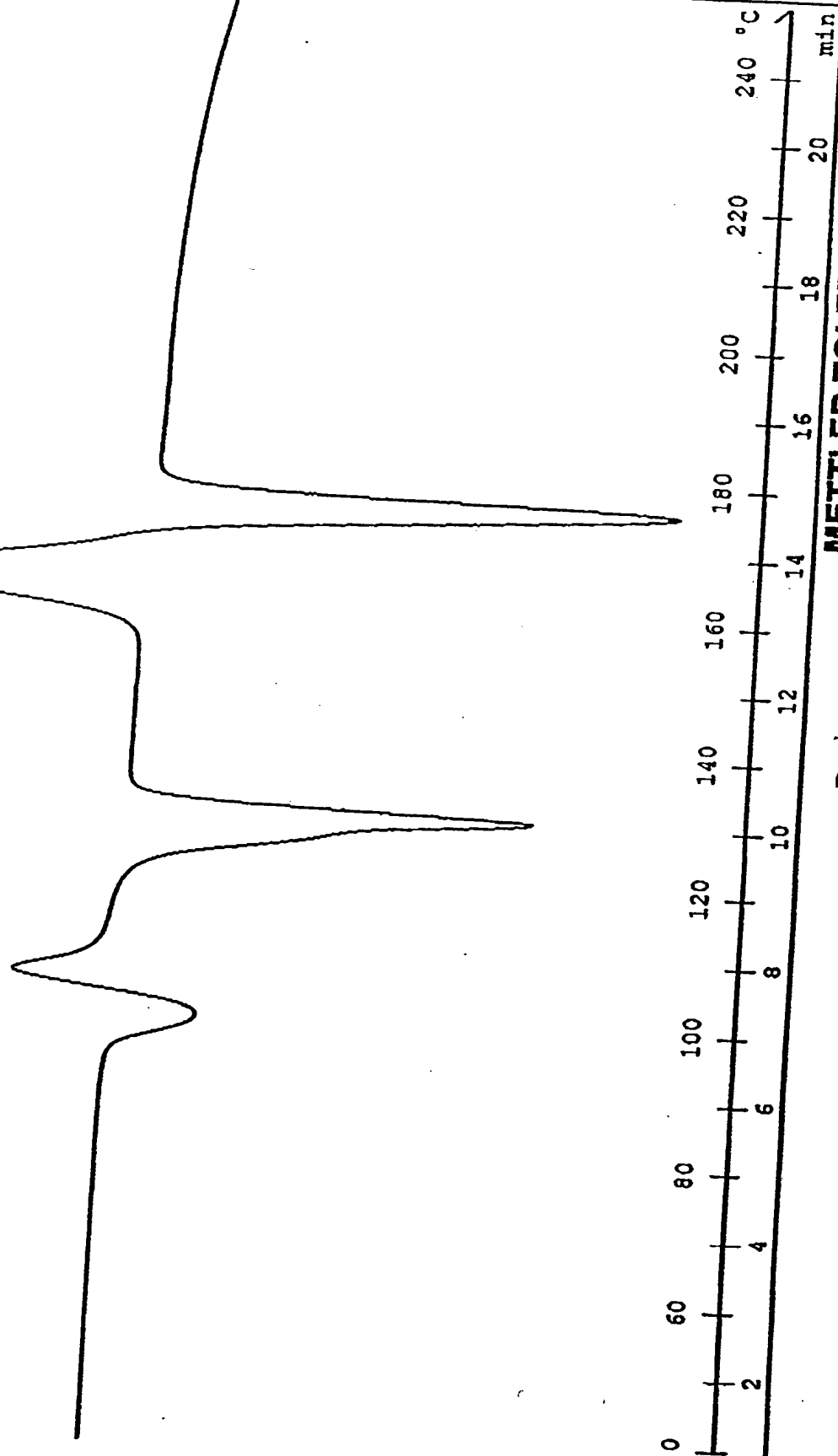
Method: 30-250°C, 10°C/min, 40ml/min N2  
30.0-250.0°C 10.00°C/min N2, 40.0 ml/min



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FIGURE 55 58  
Form Delta

Method: 30-250C, 10C/min, 40ml/min N2  
30.0-250.0°C 10.00°C/min  
N2, 40.0 ml/min

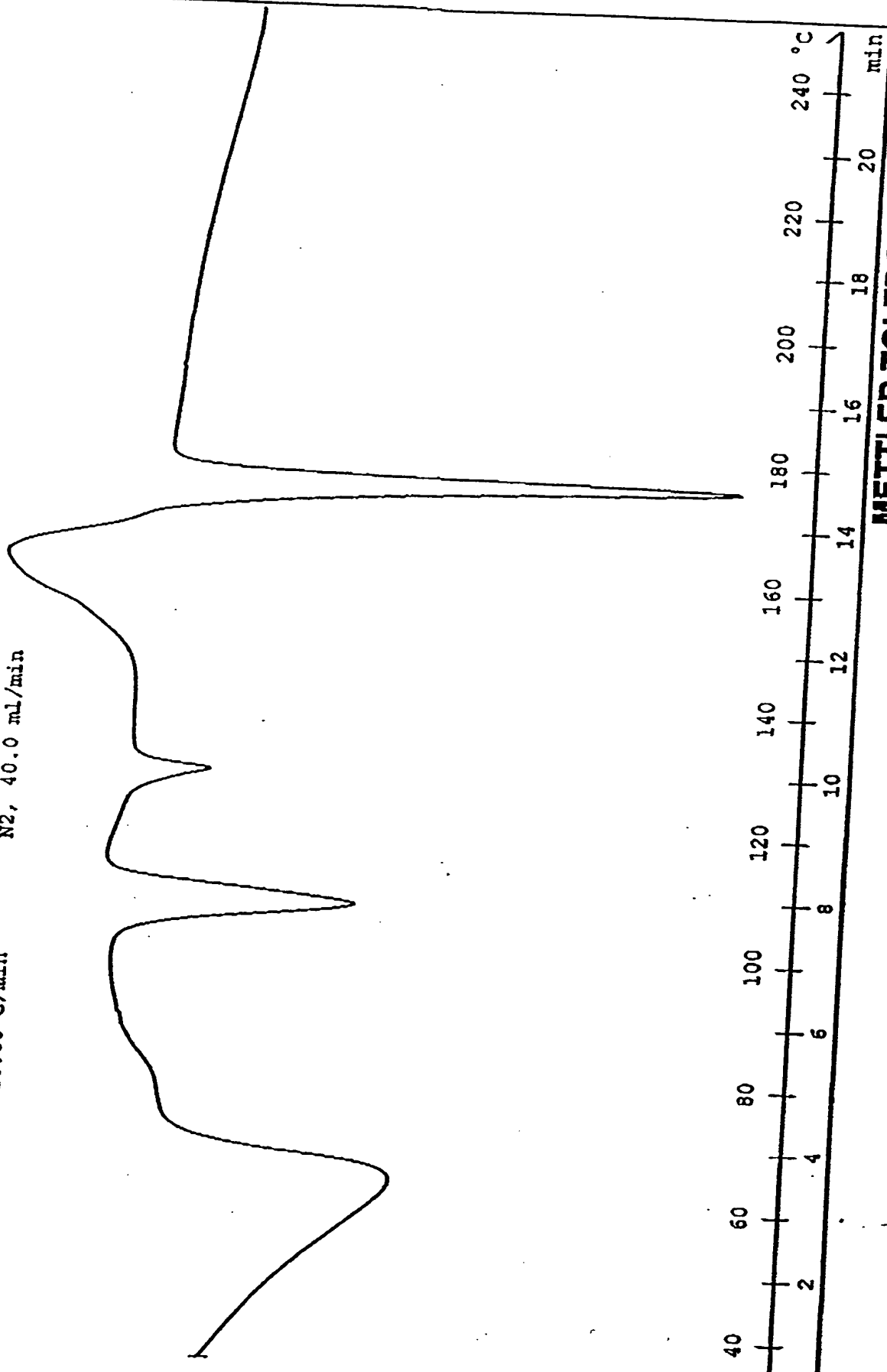


- Delta  
METTLER TOLEDO STAR® System

Form Epsilon <sup>59</sup>

FIGURE 56

Method: 30-250C, 10C/min, 40ml/min N2  
30.0-250.0°C 10.00°C/min  
N2, 40.0 ml/min

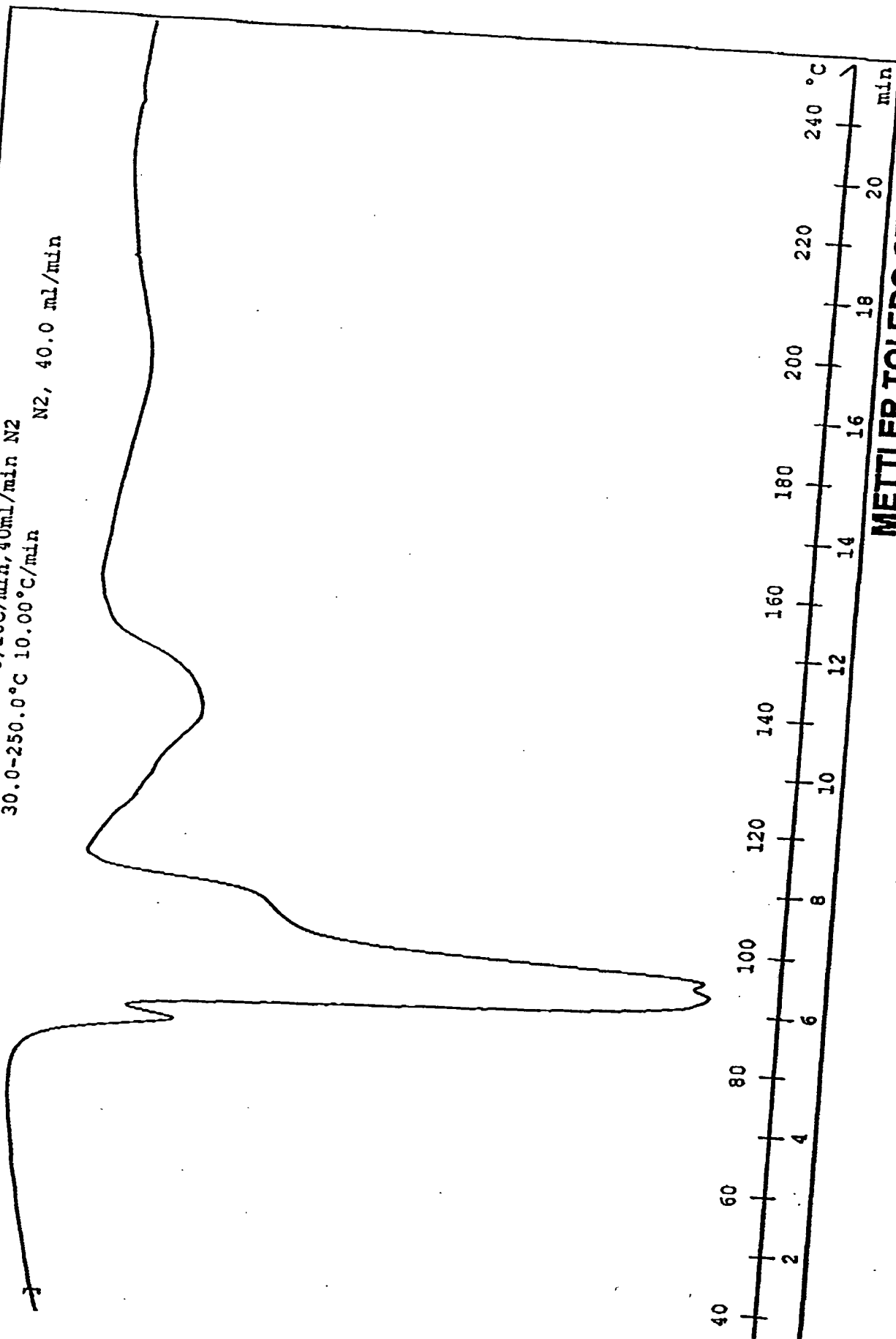


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60  
FIGURE 57

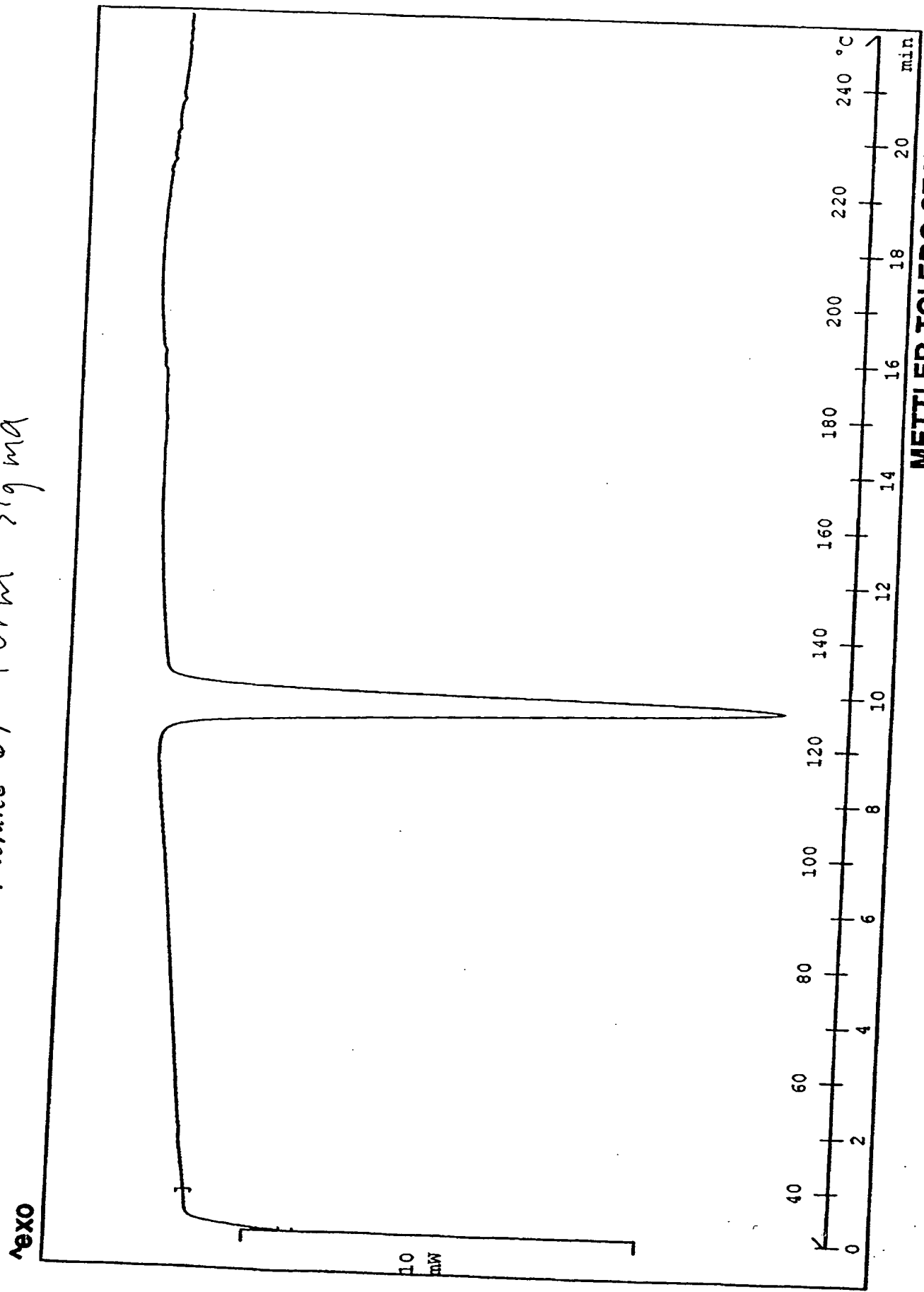
Form ~~P~~ Gamma

Method: 30-250C, 10C/min, 40ml/min N2  
30.0-250.0°C 10.00°C/min N2, 40.0 ml/min



METTTLER TOLEDO STAR® System

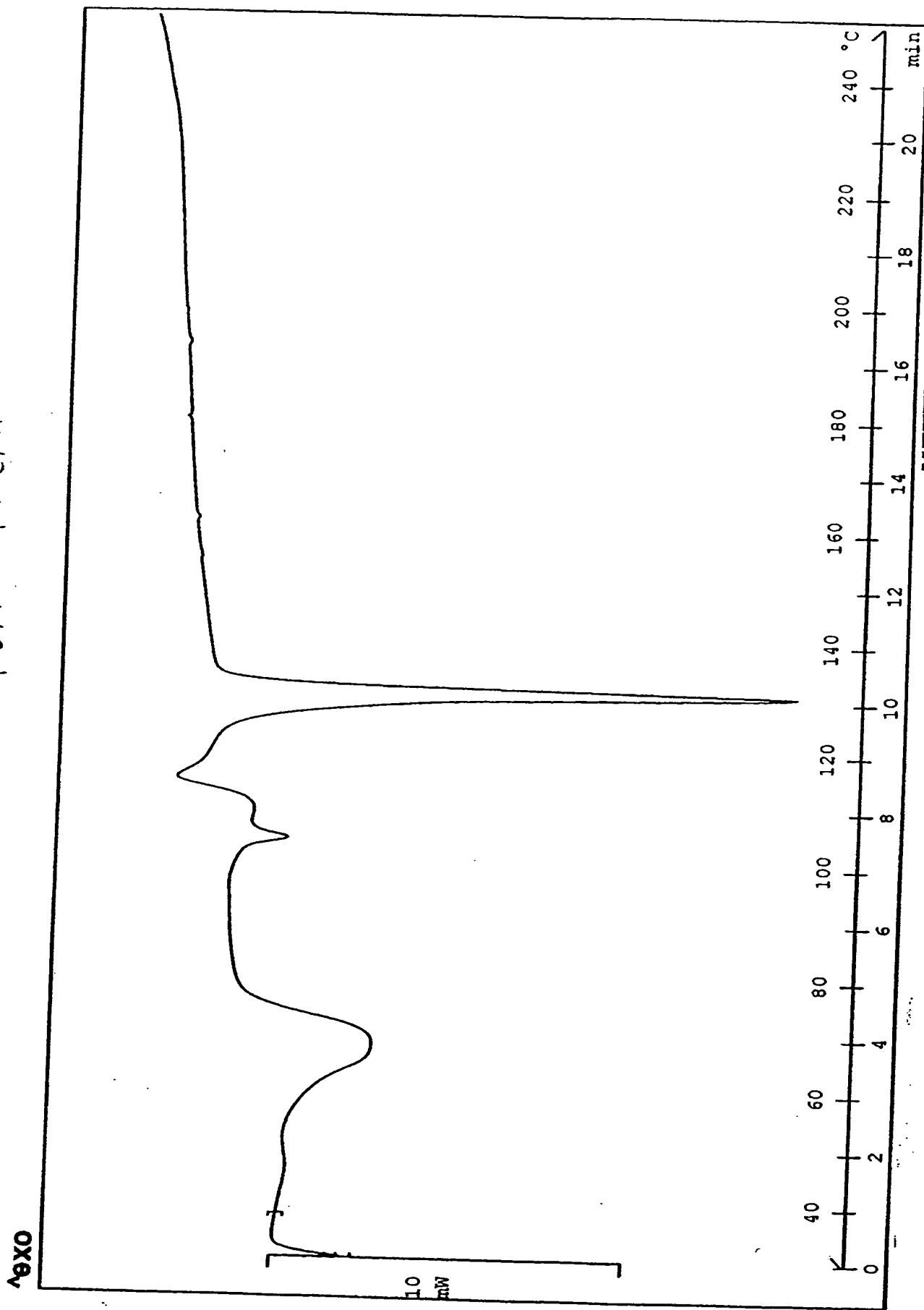
Picture 61 Form Sigma



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Form ~ (5)

FIGURE 50 62 Form Theta



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Form Θ

Figure 63

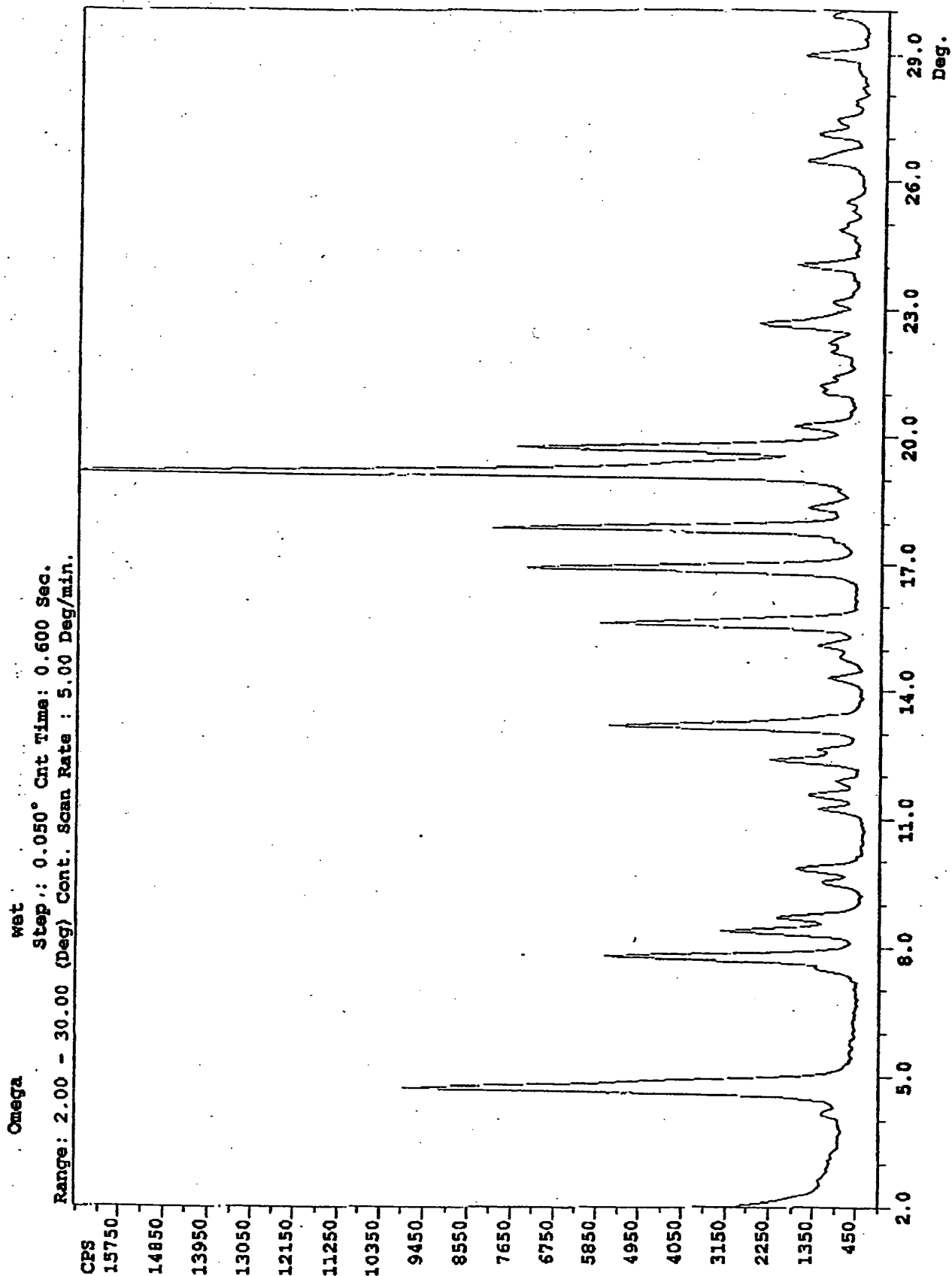




Figure 64

Comparison between the impurity profile of Nateglinide crystallized in IPA-H<sub>2</sub>O and Nateglinide crystallized in Methanol-H<sub>2</sub>O

| Sample No | Solvent                   | Impurity profile by RRT [% w/w] |        |        |        |                 |                 |                        |
|-----------|---------------------------|---------------------------------|--------|--------|--------|-----------------|-----------------|------------------------|
|           |                           | D-PA<br>(0.23)                  | (0.25) | (0.46) | (0.80) | Ipcha<br>(0.89) | Dimer<br>(1.38) | Methyl Ester<br>(1.51) |
| RL-2155/1 | Methanol-H <sub>2</sub> O | <0.01                           |        | 0.02   | <0.01  | 0.03            | 0.02            | 2.91                   |
| RL-2163/4 | IPA-H <sub>2</sub> O      | <0.01                           | 0.04   |        | 0.02   | 0.02            | 0.01            | 0.04                   |
|           |                           |                                 |        |        |        |                 |                 | 0.03                   |
|           |                           |                                 |        |        |        |                 |                 | 0.02                   |

Note: D-PA means D-Phenyl Alanine

Ipcha means Iso propyl cyclohexyl carboxylic acid

Both are the starting materials of the product

(-)-N-[(trans-4-isopropyl cyclohexane)carbonyl]-D-phenylalanine